

STATE OF MONTANA
Department of Environmental Quality
Helena, Montana 59620

AIR QUALITY OPERATING PERMIT

Permit Number: **OP1821-00**
Permit Application Received: **July 11, 1995**
Application Deemed Administratively Complete: **July 11, 1995**
Application Deemed Technically Complete: **August 12, 1996**
AFS Number: **111-0012A**

Draft Issue Date: **January 5, 2001** Proposed Issue Date: **August 13, 2001**
End of EPA 45-day Review: **September 30, 2001** Date of Decision: **October 12, 2001**
Effective Date: **November 11, 2001** Expiration Date: **November 11, 2006**

In accordance with Section 75-2-217 and 218, Montana Code Annotated, and Administrative Rules of Montana (ARM), Title 17, Chapter 8, Subchapter 12, Operating Permit Program, ARM 17.8.1201, *et seq.*,

Cenex Harvest States Cooperatives
Laurel Refinery
S ½, Section 16, Township 2 South, Range 24 East, Yellowstone County
P.O. Box 909, 802 South Highway 212
Laurel, Montana 59044-0909

hereinafter referred to as "Cenex," is authorized to operate a stationary source of air contaminants consisting of the emission units described in this permit. Until this permit expires or is modified or revoked, the permittee is allowed to discharge air pollutants in accordance with the conditions of this permit. All conditions in this permit are federally and state enforceable unless otherwise specified. Requirements that are only state enforceable are identified in the permit. A copy of this permit must be kept on site at the above-named facility.

Issued by the Department of Environmental Quality

_____/_____/_____
Signature Date

Permit Issuance and Appeal Processes: Pursuant to ARM 17.8.1210(j), the Department of Environmental Quality's (Department) decision regarding issuance of an operating permit is not effective until 30 days have elapsed from the date of decision (October 12, 2001). The decision may be appealed to the Board of Environmental Review (Board) by filing a request for hearing within 30 days (November 11, 2001) after the date of decision. The filing of a timely request for a hearing postpones the effective date (November 11, 2001) of the Department's decision until the Board issues a final decision. If no appeal is filed, the Department will send a notification and final permit cover page to be attached to this document stating that the permit is effective (to the permittee, the Environmental Protection Agency (EPA), and any interested person requesting a copy). In addition ARM 17.8.1233 allows for any person to petition EPA within 60 days of EPA's 45 day review period (November 29, 2001) to object to the issuance of this operating permit. If EPA objects to the operating permit as a result of a petition prior to the Department's notification of a final permit, the permittee and all affected parties will be informed of the stay of an effective date. If the Department has already notified the permittee and all interested parties of the effective date of the permit, the Department shall issue a revised permit according to the procedures in ARM 17.8.1231. Questions regarding the effective date, final issuance date, and status of appeals should be directed to the Department.

Montana Air Quality Operating Permit
Department of Environmental Quality

SECTION I. GENERAL INFORMATION	1
SECTION II. SUMMARY OF EMISSION UNITS	2
SECTION III. PERMIT CONDITIONS	4
A. FACILITY-WIDE	4
B. EU001 – PLANT-WIDE AND MULTIPLE EMITTING UNIT LIMITATIONS.....	8
C. EU002 – #1 CRUDE UNIT.....	17
D. EU003 – #2 CRUDE UNIT.....	20
E. EU004 – PDA UNIT.....	21
F. EU005 – #1 AND #2 NAPHTHA UNIFINERS.....	22
G. EU006 – MIDDLE DISTILLATE UNIFINER	23
H. EU007 – PLATFORMER UNIT.....	24
I. EU008 – FLUID CATALYTIC CRACKING (FCC) UNIT.....	25
J. EU009 – ALKYLATION/BUTAMER/MEROX UNITS.....	30
K. EU010 – HYDRODESULFURIZATION (HDS) UNIT AND HYDROGEN PLANT	32
L. EU011 – SULFUR RECOVERY UNIT (SRU - NEW).....	39
M. EU012 – SULFUR RECOVERY UNIT (SRU - OLD)	44
N. EU013 – STEAM GENERATION UNITS	48
O. EU014 – TANK FARM	55
P. EU015– TRANSFER FACILITIES	56
Q. EU016 – WASTEWATER TREATMENT UNITS.....	61
R. EU017 – FLARE SYSTEM.....	62
S. EU018 – RCRA UNITS	63
T. EU019 – COOLING TOWERS.....	64
U. EU020 – SATURATE GAS CONCENTRATION UNIT	64
SECTION IV. NON-APPLICABLE REQUIREMENTS	66
A. FACILITY-WIDE	66
B. EMISSION UNITS	67
SECTION V. GENERAL PERMIT CONDITIONS	68
A. COMPLIANCE REQUIREMENTS	68
B. CERTIFICATION REQUIREMENTS	68
C. PERMIT SHIELD.....	69
D. MONITORING, RECORDKEEPING, AND REPORTING REQUIREMENTS	70
E. PROMPT DEVIATION REPORTING	71
F. EMERGENCY PROVISIONS	71
G. INSPECTION AND ENTRY	72
H. FEE PAYMENT.....	72
I. MINOR PERMIT MODIFICATIONS.....	73
J. CHANGES NOT REQUIRING PERMIT REVISION	73
K. SIGNIFICANT PERMIT MODIFICATIONS.....	74
L. REOPENING FOR CAUSE.....	75
M. PERMIT EXPIRATION AND RENEWAL	75
N. SEVERABILITY CLAUSE	76
O. TRANSFER OR ASSIGNMENT OF OWNERSHIP.....	76
P. EMISSIONS TRADING, MARKETABLE PERMITS, ECONOMIC INCENTIVES	76
Q. NO PROPERTY RIGHTS CONVEYED	76
R. TESTING REQUIREMENTS.....	76
S. SOURCE TESTING PROTOCOL.....	77

T. MALFUNCTIONS.....	77
U. CIRCUMVENTION	77
V. MOTOR VEHICLES	77
W. ANNUAL EMISSIONS INVENTORY	77
X. OPEN BURNING.....	77
Y. PRECONSTRUCTION PERMITS	77
Z. NATIONAL EMISSION STANDARD FOR ASBESTOS	78
AA. ASBESTOS	78
BB. STRATOSPHERIC OZONE PROTECTION – SERVICING OF MOTOR VEHICLE AIR CONDITIONERS	79
CC. STRATOSPHERIC OZONE PROTECTION – RECYCLING AND EMISSION REDUCTIONS...	79
DD. EMERGENCY EPISODE PLAN.....	79
EE. DEFINITIONS	79
App. A RULE CITATION	A-1
App. B INSIGNIFICANT EMISSION UNITS	B-1
App. C DEFINITIONS and ABBREVIATIONS	C-1
App. D NOTIFICATION ADDRESSES	D-1
App. E AIR QUALITY INSPECTOR INFORMATION	E-1
App. F JUNE 12, 1998 BOARD ORDERS ADOPTING A SO₂ CONTROL PLAN F-1	

Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit have the meaning assigned to them in the referenced regulations.

SECTION I. GENERAL INFORMATION

The following general information is provided pursuant to ARM 17.8.1210(1).

Company Name: **Cenex Harvest States Cooperatives Laurel Refinery**

Mailing Address: **P.O. Box 909, 802 South Highway 212**

City: **Laurel**

State: **Montana**

Zip: **59044-0909**

Plant Location: **S ½, Section 16, Township 2 South, Range 24 East, Yellowstone County**

Responsible Official: **Patrick B. Kimmet** Phone: **(406) 628-5220**

Facility Contact Person: **Max Sims** Phone: **(406) 628-5334**

Primary SIC Code: **2911**

Nature of Business: **Petroleum Refining**

Description of Process: **The refining process distills crude oil using heat. This distillation separates the crude oil into its component parts. The refiner then cracks some of the heavier molecules by applying heat in the presence of a catalyst to make the reaction take place. These raw products are then treated in several ways to take out impurities. Finally, the proper liquids and additives are blended to create the desired product.**

SECTION II. SUMMARY OF EMISSION UNITS

The emission units regulated by this permit are the following (ARM 17.8.1211):

Emission Unit ID	Description	Pollution Control Device/Practice
EU001	Plant-wide and Multiple Emitting Unit Limitations	Permit #1821-05 Limits, Billings/Laurel SO ₂ Stipulation, and MACT LDAR program, where applicable
EU002	#1 Crude Unit <ul style="list-style-type: none"> - #1 Crude Unit Preheater - #1 Crude Unit Main Heater - #1 Crude Unit Vacuum Heater 	CEMS on Refinery Fuel Gas Header, LDAR, Billings/Laurel SO ₂ Stipulation
EU003	#2 Crude Unit <ul style="list-style-type: none"> - #2 Crude Unit Preheater - #2 Crude Unit Main Heater - #2 Crude Unit Vacuum Heater 	CEMS on Refinery Fuel Gas Header, LDAR, Billings/Laurel SO ₂ Stipulation
EU004	PDA Unit <ul style="list-style-type: none"> - PDA Asphalt Heater 	CEMS on Refinery Fuel Gas Header, Billings/ Laurel SO ₂ Stipulation
EU005	#1 & #2 Naphtha Unifiners <ul style="list-style-type: none"> - #1 Naphtha Unifiner Charge Heater - #1 Naphtha Unifiner Stripper Reboiler Heater - #1 Naphtha Unifiner Splitter Reboiler Heater - #2 Naphtha Unifiner Charge, Reboiler Heater - #1 Unifiner Compressor Engine - #2 Unifiner Compressor Engine 	CEMS on Refinery Fuel Gas Header, LDAR, Billings/Laurel SO ₂ Stipulation
EU006	Middle Distillate Unifiner <ul style="list-style-type: none"> - Middle Distillate Unifiner Charge Heater - Middle Distillate Unifiner Stripper Reboiler Heater - #3 Unifiner Compressor Engine - #4 Unifiner Compressor Engine 	CEMS on Refinery Fuel Gas Header, Billings/ Laurel SO ₂ Stipulation
EU007	Platformer Unit <ul style="list-style-type: none"> - Platformer Heater - Platformer Debutanizer Reboiler Heater - Platformer Recycle Compressor Turbine 	CEMS on Refinery Fuel Gas Header, LDAR, Billings/Laurel SO ₂ Stipulation
EU008	Fluid Catalytic Cracking (FCC) Unit <ul style="list-style-type: none"> - FCC Feed Preheater - FCC CO Boiler and FCC Regenerator 	CEMS on Refinery Fuel Gas Header, LDAR, SO ₂ CEMS, Billings/Laurel SO ₂ Stipulation
EU009	Alkylation/Butamer/Merox Units <ul style="list-style-type: none"> - Alkylation Unit Hot Oil Belt Heater - Miscellaneous Process Vent (Alkylation Unit Butamer Stabilizer Offgas) 	CEMS on Refinery Fuel Gas Header, LDAR, Billings/Laurel SO ₂ Stipulation

Emission Unit ID	Description	Pollution Control Device/Practice
EU010	Hydrodesulfurization Unit and Hydrogen Plant <ul style="list-style-type: none"> - Reformer Heater - Reactor Charge Heater - Fractionator Feed Heater - Hydrogen Compressor Gas Engine 	CEMS on Refinery Fuel Gas Header, LDAR, Permit #1821-05 Limits, Low NO _x Technology (on heaters), Billings/Laurel SO ₂ Stipulation
EU011	Sulfur Recovery Unit (New)	Permit #1821-05 Limits, Low NO _x Technology, SO ₂ CEMS, Billings/Laurel SO ₂ Stipulation
EU012	Sulfur Recovery Unit (Old) (made up of the #1 SRUs) <ul style="list-style-type: none"> - #1 Sulfur Recovery Unit Incinerator 	SO ₂ CEMS, Billings/ Laurel SO ₂ Stipulation
EU013	Steam Generation Units <ul style="list-style-type: none"> - #1 Fuel Oil Heater - #2 Fuel Oil Heater - #9 Boiler - #3 Boiler - #4 Boiler - #5 Boiler - #10 Boiler 	CEMS on Refinery Fuel Gas Header, Permit #1821-05 Limits Fuel Oil Flow Meters (#3, # 4, #5 Boilers) LDAR and Low NO _x Technology (#10 Boiler), Billings/ Laurel SO ₂ Stipulation
EU014	Tank Farm <ul style="list-style-type: none"> - MACT Group 1 Storage Vessels: Tanks 61, 70, 74, 75, 78, 82, 83, 93, 95, 100, 101, 102, 103, 108, 109, 110, 112 - MACT Group 2 Storage Vessels: Tanks 2, 4, 6, 7, 9, 11, 12, 23 (being converted to floating roof to meet Group 1 criteria), 25, 28, 29, 41, 43, 44, 47, 52, 55, 56, 60, 62, 63, 64, 65, 66, 67, 68, 71, 73, 76, 77, 79, 80, 81, 85, 86, 87, 88, 89, 90, 91, 92, 94, 96, 97, 98, 99, 104, 105, 106, 107, 111, 113, 114, 115, 116, 117, 118 (Wastewater Treatment, meets Group 1 criteria), 119, 120, 121, 122, 601, BP-2 - Other: Tanks 123, B-1, B-2, B-7, firetk 1, firetk 2, firetk 3, firetk 4, tank 60 heater, tank BP2 heater. 	Internal and External Floating Roofs, Fixed Roofs, LDAR (as applicable), Billings/ Laurel SO ₂ Stipulation
EU015	Transfer Facilities <ul style="list-style-type: none"> - Asphalt Loading Heater #1 - Asphalt Loading Heater #2 - Pitch Flaker & #4 Cooling Tower - Product Loading Rack Vapor Combustion Unit (VCU) 	Vapor Combustion Unit on Light Product Truck Loading Rack LDAR, Billings/Laurel SO ₂ Stipulation
EU016	Wastewater Treatment Units	Enclosed conveyance and other wastewater controls for affected equipment per NSPS QQQ
EU017	Flare System	Flare, Billings/Laurel SO ₂ Stipulation
EU018	RCRA Units	Restrictions on Land Tillage (HWSA permit)
EU019	Cooling Towers	None
EU020	Saturate Gas Concentration Unit	None

SECTION III. PERMIT CONDITIONS

The following requirements and conditions are applicable to the facility or to specific emission units located at the facility (ARM 17.8.1211,1212, and 1213).

A. Facility-Wide

Conditions	Rule Citation	Rule Description	Pollutant/Parameter	Limit
A.1	ARM 17.8.106	Source Testing Protocol	Testing, Recordkeeping, and Reporting Requirements	-----
A.2	ARM 17.8.304(1)	Visible Air Contaminants	Opacity	40%
A.3	ARM 17.8.304(2)	Visible Air Contaminants	Opacity	20%
A.4	ARM 17.8.304(3)	Visible Air Contaminants	Opacity	60%
A.5	ARM 17.8.308(1)	Particulate Matter, Airborne	Fugitive Opacity	20%
A.6	ARM 17.8.308(2)	Particulate Matter, Airborne	Reasonable Precautions	-----
A.7	ARM 17.8.308(3)	Particulate Matter, Airborne	Reasonable Precaution, Construction	20%
A.8	ARM 17.8.309	Particulate Matter, Fuel Burning Equipment	Particulate Matter	$E = 0.882 * H^{-0.1664}$ Or $E = 1.026 * H^{-0.233}$
A.9	ARM 17.8.310	Particulate Matter, Industrial Processes	Particulate Matter	$E = 4.10 * P^{0.67}$ or $E = 55 * P^{0.11} - 40$
A.10	ARM 17.8.322(4)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (liquid or solid fuels)	1 lb/MMBtu fired
A.11	ARM 17.8.322(5)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (gaseous)	50 gr/100 CF
A.12	ARM 17.8.324(3)	Hydrocarbon Emissions, Petroleum Products	Gasoline Storage Tanks	-----
A.13	ARM 17.8.324(1)	Hydrocarbon Emissions, Petroleum Products	65,000-Gallon Capacity	-----
A.14	ARM 17.8.324(2)	Hydrocarbon Emissions, Petroleum Products	Oil-effluent Water Separator	-----
A.15	ARM 17.8.342	National Emission Standards for Hazardous Air Pollutants for Source Categories (MACT)	All Applicable Provisions of 40 CFR 63 Subpart CC	-----
A.16	ARM 17.8.341	National Emission Standards for Benzene Waste Operations	All Applicable Provisions of 40 CFR 61 Subpart FF	-----
A.17	40 CFR 68	Chemical Accident Prevention	Risk Management Plan	-----
A.18	40 CFR 51	State Implementation Plan (SIP)	SO ₂	-----
A.19	40 CFR 51	State Implementation Plan (SIP)	Sulfur Bearing Gases	-----
A.20	40 CFR 51	State Implementation Plan (SIP)	Quantify Emissions	-----
A.21	ARM 17.74.336	Asbestos	Asbestos	-----
A.22	40 CFR 51	State Implementation Plan (SIP)	Reporting Requirements	-----
A.23	ARM 17.8.1212	Reporting Requirements	Compliance Monitoring	-----
A.24	ARM 17.8.1207	Reporting Requirements	Annual Certification	-----

Conditions

A.1. Pursuant to ARM 17.8.106, all emission source testing, sampling and data collection, recording analysis, and transmittal must be performed, maintained, and reported in accordance with the Montana Source Test Protocol and Procedures Manual (dated July 1994 unless superseded by rulemaking), unless alternate methods are approved by the Department.

- A.2. Pursuant to ARM 17.8.304(1), Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.
- A.3. Pursuant to ARM 17.8.304(2), Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.
- A.4. Pursuant to ARM 17.8.304(3), during the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes.
- A.5. Pursuant to ARM 17.8.308(1), Cenex shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.
- A.6. Pursuant to ARM 17.8.308(2), Cenex 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, unless otherwise specified by rule or in this permit.
- A.7. Pursuant to ARM 17.8.308(3), Cenex shall not operate a construction site or demolition project unless reasonable precautions are taken to control emissions of airborne particulate matter. Such emissions of airborne particulate matter from any stationary source shall not exhibit opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.
- A.8. Pursuant to ARM 17.8.309, unless otherwise specified by rule or in this permit, Cenex shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel burning equipment and new fuel burning equipment, calculated using the following equations:

For existing fuel burning equipment (installed before November 23, 1968):

$$E = 0.882 * H^{-0.1664}$$

For new fuel burning equipment (installed on or after November 23, 1968):

$$E = 1.026 * H^{-0.233}$$

Where H is the heat input capacity in million BTU (MMBtu) per hour and E is the maximum allowable particulate emission rate in pounds per MMBtu.

- A.9. Pursuant to ARM 17.8.310, unless otherwise specified by rule or in this permit, Cenex shall not cause or authorize particulate matter to be discharged from any operation, process, or activity into the outdoor atmosphere in excess of the maximum hourly allowable emissions of particulate matter, calculated using the following equations:

For process weight rates up to 30 tons per hour:

$$E = 4.10 * P^{0.67}$$

For process weight rates in excess of 30 tons per hour:

$$E = 55.0 * P^{0.11} - 40$$

Where E is the rate of emissions in pounds per hour and P is the process weight rate in tons per hour.

- A.10. Pursuant to ARM 17.8.322(4), Cenex shall not burn liquid or solid fuels containing sulfur in excess of 1 pound per million BTU fired, unless otherwise specified by rule or in this permit. This rule shall be interpreted to mean that no person shall burn solid, liquid, or gaseous fuels such that the aggregate sulfur content of all fuels burned within a plant during any day exceeds 1 pound of sulfur per million BTU fired. The rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per million BTU fired. The rule shall be interpreted to allow the blending of all fuels burned in a plant during a given time period in determining the aggregate sulfur content for purposes of the rule, and it shall not be construed to require blending or physical mixing of fuels at any given furnace or heater within the plant complex (Environmental Protection Agency (EPA)) approved SIP, September 1979).
- A.11. Pursuant to ARM 17.8.322(5), Cenex shall not 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, unless otherwise specified by rule or in this permit. This rule shall be interpreted to mean that no person shall burn solid, liquid, or gaseous fuels such that the aggregate sulfur content of all fuels burned within a plant during any day exceeds 1 pound of sulfur per million BTU fired. The rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per million BTU fired. The rule shall be interpreted to allow the blending of all fuels burned in a plant during a given time period in determining the aggregate sulfur content for purposes of the rule, and it shall not be construed to require blending or physical mixing of fuels at any given furnace or heater within the plant complex (Environmental Protection Agency (EPA)) approved SIP, September 1979).
- A.12. Pursuant to ARM 17.8.324(3), Cenex shall not load or permit the loading of gasoline into any stationary tank with a capacity of 250 gallons or more from any tank truck or trailer, except through a permanent submerged fill pipe, unless such tank is equipped with a vapor loss control device or is a pressure tank as described in ARM 17.8.324(1), unless otherwise specified by rule or in this permit.
- A.13. Pursuant to ARM 17.8.324(1), unless otherwise specified by rule or in this permit, Cenex shall not place, store or hold in any stationary tank, reservoir or other container of more than 65,000-gallon capacity any crude oil, gasoline or petroleum distillate having a vapor pressure of 2.5 pounds per square inch absolute or greater under actual storage conditions, unless such tank, reservoir or other container is a pressure tank maintaining

working pressure sufficient at all times to prevent hydrocarbon vapor or gas loss to the atmosphere, or is designed and equipped with a vapor loss control device, properly installed, in good working order and in operation.

- A.14. Pursuant to ARM 17.8.324(2), unless otherwise specified by rule or in this permit, Cenex shall not use any compartment of any single or multiple-compartment oil-effluent water separator which compartment receives effluent water containing 200 gallons a day or more of any petroleum product from any equipment processing, refining, treating, storing or handling of kerosene or other petroleum product of equal or greater volatility than kerosene, unless such compartment is equipped with a vapor loss control device, constructed so as to prevent emission of hydrocarbon vapors to the atmosphere, properly installed, in good working order and in operation.
- A.15. Cenex shall comply with all applicable National Emission Standards for Hazardous Air Pollutant for Source Categories (MACT) provisions, as appropriate, of 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- A.16. Cenex shall comply with all applicable standards and limitations, and the reporting, record-keeping, and notification requirements as required by 40 CFR 61, Subpart FF- National Emissions Standards for Benzene Waste Operations (ARM 17.8.341 and 40 CFR Part 61, Subpart FF).
- A.17. A Risk Management Plan, developed in accordance with 40 CFR 68, shall be registered with the United States Environmental Protection Agency by June 21, 1999. Cenex shall submit a certification statement to the Department that states Cenex is in compliance with the requirements of 40 CFR 68, including registration (40 CFR 68.150 and 160).
- A.18. Pursuant to the June 12, 1998, Board Order adopting a sulfur dioxide control plan, Cenex shall comply with all requirements of Exhibit A, Exhibit A-1, and Attachments 1 and 2 of the plan (Board Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by EPA (See Appendix F of this permit)).
- A.19. Cenex shall utilize appropriate maintenance, repair, and operating practices to control emissions of sulfur bearing gases from minor sources such as ducts, stacks, valves, vents, vessels, and flanges which are not otherwise subject to Stipulation and Exhibit A (Board Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by EPA).
- A.20. Cenex shall use good engineering judgement and appropriate engineering calculations to quantify emissions from activities that are not otherwise addressed by the Stipulation and Exhibit A, but are known to contribute to emissions from sources listed in Exhibit A, Section 1(B). In addition, Cenex shall account for such emissions in determining compliance with all applicable emission limits contained in Exhibit A, Section 3 (Board Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by EPA).
- A.21. Pursuant to ARM 17.74.336, Cenex shall comply with all the limitations and requirements of their Asbestos Abatement Annual Permit #MTF0003.

Reporting

- A.22. Pursuant to the June 12, 1998, Board Order adopting a sulfur dioxide control plan, Cenex shall comply with all reporting requirements of Exhibit A, Exhibit A-1, and Attachment 1 of the plan (Board Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by EPA).
- A.23. On or before January 31 and July 31 of each year, Cenex shall submit to the Department the compliance monitoring reports required by Section V.D. These reports must contain all information required by Section V.D, as well as the information required by each individual emission unit. For the reports due by January 31 of each year, Cenex may submit a single report provided that it contains all the information required by Section V.B and V.D (ARM 17.8.1212).
- A.24. By January 31 of each year, Cenex shall submit to the Department the compliance certification report required by Section V.B. The annual certification report required by Section V.B must include a statement of compliance based on the information available which identifies any observed, documented or otherwise known instance of noncompliance for each applicable requirement (ARM 17.8.1212).

B. EU001 – Plant-wide and Multiple Emitting Unit Limitations

Plant-wide Limitations: Plant-wide refinery (excepting the refinery flare)

Multiple Emitting Unit Limitations (only includes SIP limitations that cover more than one emitting unit, individual emitting unit SIP limits are included under that emitting unit):

Refinery fuel oil combustion sources: #3, #4, and #5 boiler stacks; and main crude heater stack
Fuel gas-fired sources

- HDS complex fuel gas-fired units: H-101 heater, H-201 heater, H-202 heater, SRU reheater E-407, and incinerator INC-401
- Pre-1990 fuel gas-fired units: FCC CO boiler, alkylation unit hot oil belt heater, crude preheater, Platformer heater-4 sections, #1 Naphtha Unifiner charge heater, #1 Naphtha Unifiner stripper heater, Naphtha Unifiner splitter heater, MDU stripper heater, MDU charge heater, PDA asphalt heater, #2 N.U. heater-2, platformer debutanizer heater, #2 crude heater, #2 vacuum heater, #1 vacuum heater, FCC preheater, #9 boiler, saturated gas concentration hot oil heater, asphalt loading heaters (2), tank BP-2 heater, 60 Tank Heater, and the fuel can heaters (2) #10 boiler

Sulfur in fuel rule applicable sources (per the 1979 Stipulation, this applies to the facility, not unit by unit)

- EU002: #1 Crude Unit and #1 Crude Unit Vacuum Heater; EU003: #2 Crude Unit; EU004: PDA Unit; EU005: #1 and #2 Naphtha Unifiners; EU006: Middle Distillate Unifiner; EU007: Platformer Unit; EU008: FCC Unit; EU009: Alkylation/Butamer/Merox Units; EU013: Steam Generation Units; and EU015: Asphalt Loading Heater #1.

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirement
			Method	Frequency	
B.1, B.11, B.14, B.15, B.17, B.18, B.19, B.20, B.21, B.25	Plant-wide: SO ₂	2980.3 ton/yr	Logging	Ongoing	Quarterly
B.2, B.11, B.17, B.18, B.20, B.21, B.25	Plant-wide: NO _x	999.4 ton/yr	Logging	Ongoing	Quarterly
B.3, B.11, B.17, B.18, B.20, B.21, B.25	Plant-wide: CO	530.7 ton/yr	Logging	Ongoing	Quarterly
B.4, B.11, B.17, B.18, B.20, B.21, B.25	Plant-wide: VOC	1967.5 ton/yr	Logging	Ongoing	Quarterly
B.5, B.11, B.17, B.18, B.20, B.21, B.25	Plant-wide: PM-10	152.2 ton/yr	Logging	Ongoing	Quarterly
B.6, B.11, B.17, B.18, B.20, B.21, B.25	Plant-wide: TSP	162.2 ton/yr	Logging	Ongoing	Quarterly
B.7, B.12, B.13, B.14, B.15, B.18, B.19, B.20, B.22, B.23, B.24, B.25	SIP: SO ₂ for fuel oil and/or fuel gas burning sources only	3,014.7 lb/3-hour Period	SO ₂ /H ₂ S CEMS, SWS continuous flow rate monitor, Sampling	Ongoing	Quarterly
			Method 11	Annually	Semi-annual
B.8, B.12, B.13, B.14, B.15, B.18, B.19, B.20, B.22, B.23, B.24, B.25	SIP: SO ₂ for fuel oil and/or fuel gas burning sources only	24,117.6 lb/ Calendar Day	SO ₂ /H ₂ S CEMS, SWS continuous flow rate monitor, Sampling	Ongoing	Quarterly
			Method 11	Annually	Semi-annual
B.9, B.12, B.13, B.14, B.15, B.18, B.19, B.20, B.22, B.23, B.24, B.25	SIP: SO ₂ for fuel oil and/or fuel gas burning sources only	8,802,924 lb/ Calendar Year	SO ₂ /H ₂ S CEMS, SWS continuous flow rate monitor, Sampling	Ongoing	Quarterly
			Method 11	Annually	Semi-annual
B.10, B.16, B.18, B.19, B.25	Sulfur Oxide Emissions, Sulfur in Fuel	50 gr/100 CF	H ₂ S CEMS and/or	Ongoing	Semi-annual
			Method 11	Annually	

Conditions

- B.1. Annual plant-wide emission limitation: SO₂ emissions shall not exceed 2980.3 tons per year (ARM 17.8.710).
- B.2. Annual plant-wide emission limitation: NO_x emissions shall not exceed 999.4 tons per year (ARM 17.8.710).
- B.3. Annual plant-wide emission limitation: CO emissions shall not exceed 530.7 tons per year (ARM 17.8.710).
- B.4. Annual plant-wide emission limitation: VOC emissions shall not exceed 1967.5 tons per year (ARM 17.8.710).
- B.5. Annual plant-wide emission limitation: PM-10 emissions shall not exceed 152.2 tons per year (ARM 17.8.710).
- B.6. Annual plant-wide emission limitation: TSP emissions shall not exceed 162.2 tons per year (ARM 17.8.710).

- B.7. Cenex shall not cause or authorize total SO₂ emissions from refinery combustion sources and fuel gas-fired sources to exceed the limit of 3,014.7 pounds per 3-hour period (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- B.8. Cenex shall not cause or authorize total SO₂ emissions from refinery combustion sources and fuel gas-fired sources to exceed the limit of 24,117.6 pounds per calendar day (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- B.9. Cenex shall not cause or authorize total SO₂ emissions from refinery combustion sources and fuel gas-fired sources to exceed the limit of 8,802,924 pounds per calendar year (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- B.10. Cenex shall not 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, unless otherwise specified by rule or in this permit (ARM 17.8.322(5)).

Compliance Demonstration

- B.11. Cenex will track compliance with the annual plant-wide emission limitation based on source type, pollutant, calculation basis (emission factors, estimated yield and conversion), and key parameters (fuel oil use, fuel gas use, process gas use, and CEMS data). The units included in each source type are listed in Section II.A of the Technical Review Document (TRD) (ARM 17.8.710).
 - a. Gas-fired external combustion
 - i. SO₂
 - 1. Calculation Basis: AP-42 Section 1-4 (7/98 revision) and complete conversion of fuel gas H₂S to SO₂
 - 2. Key Parameters: Monthly fuel use (scf) per combustion unit and refinery fuel gas H₂S content from CEMS
 - ii. NO_x, CO, PM-10/TSP, VOC
 - 1. Calculation Basis: AP-42 Section 1-4 (7/98 revision)
 - 2. Key Parameters: Monthly fuel use (scf) per combustion unit and monthly average fuel gas heat content
 - b. Fuel oil-fired external combustion
 - i. SO₂
 - 1. Calculation Basis: Methodology required in the Billings-Laurel SO₂ SIP
 - 2. Key Parameters: Monthly fuel oil use (lb) per combustion unit and test for fuel oil Sulfur content pursuant to Billings-Laurel SO₂ SIP
 - ii. NO_x, CO, PM-10/TSP, VOC
 - 1. Calculation Basis: AP-42 Section 1-3 (9/98 revision including the 4/28/00 Errata)

- 2. Key Parameters: Monthly fuel oil use (lb) per combustion unit
- c. Gas-fired internal combustion
- i. SO₂
 - 1. Calculation Basis: AP-42 Section 1-4 (7/98 revision) and complete conversion of fuel gas H₂S to SO₂
 - 2. Key Parameters: Monthly fuel use (scf) per combustion unit and fuel gas H₂S and Sulfur content
 - ii. NO_x, CO
 - 1. Calculation Basis: AP-42 Section 3-2 (10/96 revision)
 - 2. Key Parameters: Monthly fuel use (scf) per combustion unit and monthly average fuel gas heat content
 - iii. PM-10/TSP: Not applicable – not a significant source
 - iv. VOC
 - 1. Calculation Basis: AP-42 Section 3-2 (10/96 revision)
 - 2. Key Parameters: Monthly fuel use (scf) per combustion unit and monthly average fuel gas heat content
- d. #10 Boiler
- i. SO₂
 - 1. Calculation Basis: Complete conversion of fuel gas H₂S to SO₂
 - 2. Key Parameters: Monthly fuel use (scf) per combustion unit and refinery fuel gas H₂S content from CEMS
 - ii. NO_x
 - 1. Calculation Basis: Emission factors based on stack tests
 - 2. Key Parameters: NO_x stack tests, monthly fuel use (scf)
 - iii. CO
 - 1. Calculation Basis: Emission factors based on stack tests
 - 2. Key Parameters: CO stack tests, monthly fuel use (scf)
 - iv. PM-10/TSP
 - 1. Calculation Basis: AP-42 Section 1-4 (7/98 revision)
 - 2. Key Parameters: Monthly fuel use (scf) and monthly average fuel gas heat content
 - v. VOC
 - 1. Calculation Basis: Emission factors based on stack tests
 - 2. Key Parameters: VOC stack tests, monthly fuel use (scf)
- e. Zone D combustion sources
- i. SO₂: Calculation Basis: CEMS data and methodology required in the Billings/Laurel SO₂ SIP

- ii. NO_x
 - 1. Calculation Basis: Emission factors based on annual stack tests
 - 2. Key Parameters: NO_x stack tests, monthly fuel use (scf) per combustion unit
- iii. CO
 - 1. Calculation Basis: Emission factors based on annual stack tests
 - 2. Key Parameters: CO stack tests, monthly fuel use (scf) per combustion unit
- iv. PM-10/TSP
 - 1. Calculation Basis: AP-42 Section 1-4 (7/98 revision)
 - 2. Key Parameters: Monthly fuel use (scf) per combustion unit and monthly average fuel gas heat content
- v. VOC
 - 1. Calculation Basis: Emission factors based on annual stack tests for sources burning refinery fuel gas. For sources firing only natural gas, the most current VOC stack test will be used to develop emission factors.
 - 2. Key Parameters: VOC stack test
- f. Fugitive equipment leaks
 - i. SO₂, NO_x, CO, PM-10/TSP: Not applicable (VOC emissions only)
 - ii. VOC
 - 1. Calculation Basis: EPA factors and NSPS and MACT control efficiencies (EPA-453/R-95-017)
 - 2. Key Parameters: Component counts by type and service
- g. Fluid catalytic cracking (FCC) unit
 - i. SO₂: Calculation Basis: CEMS data and methodology required in Billings/Laurel SO₂ SIP
 - ii. NO_x
 - 1. Calculation Basis: AP-42 Section 5.1 (1/95 revision)
 - 2. Key Parameters: Monthly FCC charge rate (bbl)
 - iii. CO: Maintain complete combustion (full-burn mode of operations) at the FCC unit
 - iv. PM-10/TSP
 - 1. Calculation Basis: Site specific emission factor from catalyst mass balance studies
 - 2. Key Parameters: Monthly FCC charge rate (bbl)
 - v. VOC
 - 1. Calculation Basis: AP-42 Section 5.1 (1/95 revision) and assumed 98% control efficiency
 - 2. Key Parameters: Monthly FCC charge rate (bbl)

- h. Zone A SRU Incinerator
 - i. SO₂: Calculation Basis: CEMS data and methodology required in Billings/Laurel SO₂ SIP
 - ii. NO_x, CO, PM-10/TSP, VOC
 - 1. Calculation Basis: AP-42 Section 1-4 (7/98 revision)
 - 2. Key Parameters: Monthly fuel use (scf) and average fuel gas heat content

- i. Zone D SRU Incinerator
 - i. SO₂: Calculation Basis: CEMS data and methodology required in Billings/Laurel SO₂ SIP

 - ii. NO_x
 - 1. Calculation Basis: Emission factors based on annual stack tests
 - 2. Key Parameters: Annual NO_x stack test monthly fuel use (scf)

 - iii. CO, PM-10/TSP, VOC: Not applicable – not a significant source

- j. Old sour water stripper
 - i. SO₂: Calculation Basis: CEMS data and methodology required in Billings/Laurel SO₂ SIP

 - ii. NO_x
 - 1. Calculation Basis: Methodology listed in Attachment A of permit #1821-05
 - 2. Key Parameters: Parameters described in Section II.F.5 of Permit #1821-01.

 - iii. CO, PM-10/TSP, VOC: Not applicable – not a source

- k. Wastewater
 - i. SO₂, NO_x, CO, PM-10/TSP: Not applicable – not a source

 - ii. VOC
 - 1. Calculation Basis: AP-42, Table 5.1-2 (1/95 rev.)
 - 2. Key Parameters: Monthly wastewater flow (gal) from Lab Information Management System (LIMS)

- l. Cooling towers
 - i. SO₂, NO_x, CO: Not applicable – not a source

 - ii. PM-10/TSP: Not applicable – not included in the PM-10/TSP emission cap

 - iii. VOC
 - 1. Calculation Basis: AP-42, Section 5.1 (1/95 rev.)
 - 2. Key Parameters: Monthly cooling tower circulation (gal)

m. Loading facilities

- i. SO₂: Not applicable – not a source
- ii. NO_x
 - 1. Calculation Basis: VCU stack tests for lb NO_x/gal loaded
 - 2. Key Parameters: Monthly volume of materials loaded from yield accounting
- iii. CO
 - 1. Calculation Basis: VCU stack tests for lb CO/gal loaded
 - 2. Key Parameters: Monthly volume of materials loaded from yield accounting
- iv. PM-10/TSP: Not applicable – not a significant source
- v. VOC
 - 1. Calculation Basis: AP-42, Section 5.2-4 (1/95 rev.) and VCU stack tests for lb VOC/gal loaded
 - 2. Key Parameters: Monthly volume of material throughput from yield accounting, material property data (VP, MW, etc.)

n. Storage tanks

- i. SO₂, NO_x, CO, PM-10/TSP: Not applicable – not a source
- ii. VOC
 - 1. Calculation Basis: EPA TANKS3.1
 - 2. Key Parameters: Monthly volume of material throughput from yield accounting, material property data (VP, MW, etc.)

B.12. Compliance with the SO₂ emission limitations contained in Section III.B.7, 8, and 9 shall be determined by summing the hourly SO₂ emission rates for fuel oil combustion, fuel gas combustion, and sour water stripper overheads (SWSOH) burning in the main crude heater and using the result to calculate the corresponding emission rate for each of the averaging periods (for which an emission limit in Section III.B.7, 8, and 9 applies) determined in accordance with Exhibit A, Section 6(F). The hourly SO₂ emission rate for the fuel oil combustion shall be determined by using the total hourly mass of fuel consumed as measured by the fuel oil flowmeters and fuel oil sulfur content determined in accordance with Section 6(F). The hourly SO₂ emission rate for the fuel gas combustion units shall be determined by using the H₂S concentrations and fuel gas flow rates measured by the CEMs required by Exhibit A, Section 6 (B)(3) and (4) and the sampling required by Exhibit A, Section 6(B)(3). The hourly SO₂ emission rate for the burning of SWSOH in the Main Crude Heater shall be determined by using the H₂S concentration in the SWS feed stream determined in accordance with sampling required by Exhibit A, Section 4(D) and the sour water flow rate measured by the CEMS required by Exhibit A, Section 6(B)(6). All calculations shall be made in accordance with the appropriate equation(s) in Exhibit A, Section 2(A)(1), (7), (9), and (14), except when CEMS data is not available as provided in Exhibit A, Section 2(A)(14) of the Stipulation (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

- B.13. Whenever sour water stripper overheads are being burned in the Main Crude Heater (and exhausted through the Main Crude Heater stack) or in the flare, compliance with the emission limitations contained in Section III.B.7, 8, and 9 shall be determined using flow rate monitoring data from the CEMS required by Exhibit A, Section 6(B)(6) and from sampling and analysis of the sour water feed to the "old" sour water stripper tower. Except for the first 2 hours after sour water stripper overheads are directed to the Main Crude Heater or the flare, Cenex shall collect at least one sample from the sour water feed to the "old" sour water stripper tower for each of the eight nonoverlapping 3-hour periods in a calendar day. In addition, the time elapsed before collection of the first sample shall not exceed 4 hours. Cenex shall analyze the sample for H₂S in accordance with the procedures contained in Exhibit A, Attachment #2 (or another method approved by the Department and EPA), and Cenex shall use the results to calculate the hourly SO₂ emission rate for each of the hours in the 3-hour period in accordance with the equations in Exhibit A, Section 2(A)(9) of the Stipulation. Such emission rate shall be counted against the emission limitations contained in Section III.B.7, 8, and 9 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- B.14. All gaseous (SO₂ and H₂S) continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR Part 60, Appendix F and operated in accordance with the performance specifications in 40 CFR Part 60, Appendix B, Performance Specification 2 and 7 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- a. For the FCC Regenerator/CO boiler stack CEMS, old SRU tail gas oxidizer stack CEMS, and HDS complex SRU stack CEMS, said CEMS shall be required to be maintained such that it is available and operating at least 90% of the source operating time during any reporting period (quarterly).
 - b. For the Fuel Oil Combustion Unit (#3, #4, and #5 boilers and Main Crude Heater) CEMS, said CEMS shall be required to be maintained such that it is available and operating at least 94% of the source operating time during any reporting period (quarterly).
 - c. For the Fuel Gas Combustion Unit CEMS:
 - i. If the 3-hour emissions from the fuel gas combustion units never exceed 300 pounds at any time during a calendar quarter or if the only exceedances are caused by malfunctions, Cenex shall achieve a quarterly data recovery rate (QDRR) for each pair of H₂S concentration and fuel gas flow rate monitors of at least 90%; or
 - ii. If the 3-hour emissions from the fuel gas combustion units exceed 300 pounds at any time during a calendar quarter and one or more of the exceedances are not caused by a malfunction, Cenex shall achieve a quarterly data recovery rate (QDRR) for each pair of H₂S concentration and fuel gas flow rate monitors of at least 94%.

- d. For the sour water system CEMS (measures sour water flow rate to the “old” sour water stripper tower), said CEMS shall be required to be maintained such that it is available and operating at least 94% of the source operating time during any reporting period (quarterly).
- B.15. In order to certify the hydrogen sulfide concentration in parts per million for the HDS complex fuel gas-fired units and the pre-1990 fuel gas-fired units, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Method 11) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 of this permit (ARM 17.8.106) (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- B.16. Compliance with the Sulfur in Fuel Rule (ARM 17.8.322(5)), shall be demonstrated by performance of annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Method 11) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106) and/or determined by using the H₂S concentrations and fuel gas flow rates measured by the CEMs where otherwise required (ARM 17.8.1213).

Recordkeeping

- B.17. Cenex shall complete the recordkeeping as required by Section III.B.11 (ARM 17.8.1212).
- B.18. Recordkeeping compiled for purposes of demonstrating compliance with emission limitations shall be retained by Cenex for a minimum of 5 years (ARM 17.8.1212).
- B.19. CEMS data shall be recorded by a data collections system and shall be maintained by Cenex under Cenex’s control for at least 5 years after the date of data generation. This data shall be made available to Department personnel upon request and shall be submitted to the Department upon request (ARM 17.8.1212).
- B.20. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

- B.21. Cenex shall provide quarterly emission reports to demonstrate compliance with Section III.B.1, 2, 3, 4, 5, and 6 using data required in Section III.B.11. The quarterly report shall also include CEMS monitoring downtime that occurred during the reporting period (ARM 17.8.710).
- B.22. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- B.23. Cenex shall notify the Department in writing of each annual source test a minimum of 25 working days prior to the actual testing, unless otherwise specified by the Department (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

- B.24. In accordance with Section 7 of the Stipulation (Appendix F of this permit), Cenex shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance Division office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- B.25. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):
- a. Verification of compliance with plant-wide emission limits and that quarterly reports were submitted as required by Section III.B.21;
 - b. Verification of compliance with Stipulation limits and that quarterly reports were submitted as required by Section III.B.24;
 - c. A summary of the results of any source tests performed during the reporting period; and
 - d. Verification of compliance with the Sulfur in Fuels rule.

C. EU002 – #1 Crude Unit

#1 Crude Unit Preheater, #1 Crude Unit Main Heater, #1 Crude Unit Vacuum Heater

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirement
			Method	Frequency	
C.1, C.5, C.9, C.12, C.14	Opacity	40%	Method 9	As Required by the Department	Semi-annual
C.2, C.6, C.10, C.14	Equipment Leaks	Monitoring and Maintenance Plan	Log	During Performance of Program	Semi-annual
C.3, C.7, C.11, C.14	Equipment Leaks of HAP and Non-HAP VOC	Leak Detection and Repair (LDAR) Program	Log	During Performance of Program	Semi-annual
C.4, C.8, C.11, C.13, C.14	Fuel-oil Flowmeters	Must be Equipped with Fuel Oil Flowmeters	Stipulation, Method C-1 of Attachment #1	Stipulation, Method C-1 of Attachment #1	Quarterly (accuracy checks done annually)

Conditions

- C.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

- C.2. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart VV—Standards of Performance for Equipment Leaks of VOC in the Synthetic Organic Chemicals Manufacturing Industry. Subpart VV applies to the various pumps, valves, flanges, and other equipment in HAP service within the No. 1 Crude Unit (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.340; and 40 CFR 60, Subpart VV).
- C.3. The No. 1 Crude Unit shall be maintained and operated as per the Leak Detection and Repair (LDAR) Program. The LDAR program would apply to new equipment in both hazardous air pollutant (HAP) and non-HAP VOC service in the No. 1 Crude Unit. The LDAR program would not apply to existing equipment in non-HAP service undergoing retrofit measures.
- Cenex shall monitor and maintain all pumps, shutoff valves, relief valves and other piping and valves associated (as defined above) with the No. 1 Crude Unit as described in 40 CFR 60.482-1 through 60.482-10. Records of monitoring and maintenance shall be maintained under Cenex’s control for a minimum of 2 years (ARM 17.8.340; 40 CFR 60, Subpart VV; and ARM 17.8.715).
- C.4. Cenex shall install, operate, and maintain two in-line fuel oil flowmeters on the fuel loop, one immediately before the fuel oil tank in use and one before the first fuel oil loop in use (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).

Compliance Demonstration

- C.5. Compliance with the opacity limitation listed in Section III.C.1 shall be determined using EPA reference Method 9 testing as required by the Department in accordance with Section III.A.1 by a qualified observer (ARM 17.8.1213).
- C.6. Cenex shall institute the monitoring and maintenance plan in accordance with 40 CFR 60, Subpart VV, as required by Section III.C.2 (ARM 17.8.342; 40 CFR 63, Subpart CC; 40 CFR 60, Subpart VV; and ARM 17.8.340).
- C.7. Cenex shall maintain a log, under Cenex’s control, of monitoring and maintenance activities on all pumps, shutoff valves, relief valves and other piping and valves associated (as defined in Section III.C.2) with the No. 1 Crude Unit as described in 40 CFR 60.482-1 through 60.482-10 (ARM 17.8.340 and 40 CFR 60, Subpart VV).
- C.8. Fuel oil flow metering shall be maintained and analyzed according to the following specifications (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency):
- a. Cenex shall operate and maintain all fuel oil flowmeters required by this control plan in accordance with Method C-1 of Attachment #1 of the Stipulation.
 - b. Cenex shall conduct daily fuel oil sampling in accordance with Method C-1 of Attachment 1 of the Stipulation.

- c. Cenex shall analyze all fuel oil samples collected, as required by Exhibit A, Section 6(F)(2), for sulfur content in accordance with Method C-1 of Attachment #1 of the Stipulation.
- d. Each fuel oil flowmeter required by this Stipulation shall demonstrate a flowmeter accuracy of 2% of the upper range value (i.e. maximum calibrated flow rate) as measured under laboratory conditions by the manufacturer or by the owner or operator, and pursuant to the calibration procedures as specified by Method C-1 of Attachment #1 of the Stipulation on an annual basis.
- e. Cenex shall archive a split (at least 200 cc) of each fuel oil sample collected as required by Exhibit A, Section 6(F)(2), in accordance with Method C-1 of Attachment #1 of the Stipulation.

Recordkeeping

- C.9. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).
- C.10. Recordkeeping for equipment leaks shall be performed in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- C.11. Cenex shall maintain, under Cenex's control, all logs required for compliance demonstration, shall make all logs available to Department personnel during inspections, and shall submit the logs to the Department upon request (ARM 17.8.1212).

Reporting

- C.12. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- C.13. In accordance with Section 7 of the Stipulation (Appendix F of this permit), Cenex shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance Division office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- C.14. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):
 - a. A summary of results of the last source testing that was performed;
 - b. A summary of all logs used to demonstrate compliance with limitations and conditions of this section;

- c. Verification of compliance with Stipulation limits and that quarterly reports were submitted as required by Section III.C.11; and
- d. Certification of compliance with 40 CFR 63, Subpart CC.

D. EU003 – #2 Crude Unit

#2 Crude Unit Main Heater, #2 Crude Unit Vacuum Heater

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
D.1, D.3, D.5, D.7, D.8	Opacity	40%	Method 9	As Required by the Department	Semi-annual
D.2, D.4, D.6, D. 8	Equipment Leaks	Monitoring and Maintenance Plan	Log	During Performance of Program	Semi-annual

Conditions

- D.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).
- D.2. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart VV—Standards of Performance for Equipment Leaks of VOC in the Synthetic Organic Chemicals Manufacturing Industry. Subpart VV applies to the various pumps, valves, flanges, and other equipment in HAP service within the No. 2 Crude Unit (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.340; and 40 CFR 60, Subpart VV).

Compliance Demonstration

- D.3. Compliance with the opacity limitation listed in Section III.E.1 shall be determined using EPA reference Method 9 testing as required by the Department in accordance with Section III.A.1 by a qualified observer (ARM 17.8.1213).
- D.4. Cenex shall institute the monitoring and maintenance plan in accordance with 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

- D.5. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).
- D.6. Recordkeeping for equipment leaks shall be performed in accordance with 40 CFR 63.648, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

- D.7. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- D.8. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):
- A summary of all logs used to demonstrate compliance with limitations and conditions of this section; and
 - Certification of compliance with 40 CFR 63, Subpart CC.

E. EU004 – PDA Unit PDA Asphalt Heater

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
E.1, E.2, E.3, E.4, E.5	Opacity	40%	Method 9	As Required by the Department	Semi-annual

Conditions

- E.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

Compliance Demonstration

- E.2. Compliance with the opacity limitation listed in Section III.E.1 shall be determined using EPA reference Method 9 testing, as required by the Department, in accordance with Section III.A.1 (ARM 17.8.1213).

Recordkeeping

- E.3. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

- E.4. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

E.5. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide a summary of results of the last source testing that was performed (ARM 17.8.1212).

F. EU005 – #1 and #2 Naphtha Unifiners

#1 Naphtha Unifiner Charge Heater, #1 Naphtha Unifiner Stripper Reboiler Heater, #1 Naphtha Unifiner Splitter Reboiler Heater, #2 Naphtha Unifiner Charge, Reboiler Heater, #1 Unifiner Compressor Engine, #2 Unifiner Compressor Engine

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
F.1, F.3, F.5, F.7, F.8	Opacity	40%	Method 9	As Required by the Department	Semi-annual
F.2, F.4, F.6, F.8	Equipment Leaks	Monitoring and Maintenance Plan	Log	During Performance of Program	Semi-annual

Conditions

- F.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).
- F.2. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart VV-Standards of Performance for Equipment Leaks of VOC in the Synthetic Organic Chemicals Manufacturing Industry. Subpart VV applies to the various pumps, valves, flanges, and other equipment in HAP service within the #1 and #2 Naphtha Unifiners Unit (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.340; and 40 CFR 60, Subpart VV).

Compliance Demonstration

- F.3. Compliance with the opacity limitation listed in Section III.F.1 shall be determined using EPA reference Method 9 testing as required by the Department in accordance with Section III.A.1 (ARM 17.8.1213).
- F.4. Cenex shall institute the monitoring and maintenance plan in accordance with 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

- F.5. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

F.6. Recordkeeping for equipment leaks shall be performed in accordance with 40 CFR 63.648, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

F.7. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

F.8. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

- a. A summary of all logs used to demonstrate compliance with limitations and conditions of this section; and
- b. Certification of compliance with 40 CFR 63, Subpart CC.

G. EU006 – Middle Distillate Unifiner

Middle Distillate Unifiner Charge Heater, Middle Distillate Unifiner Stripper Reboiler Heater, #3 Unifiner Compressor Engine, #4 Unifiner Compressor Engine

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
G.1, G.2, G.3, G.4, G.5	Opacity	20%	Method 9	As Required by the Department	Semi-annual

Conditions

G.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

Compliance Demonstration

G.2. Compliance with the opacity limitation listed in Section III.G.1 shall be determined using EPA reference Method 9 testing as required by the Department in accordance with Section III.A.1 (ARM 17.8.1213).

Recordkeeping

G.3. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

- G.4. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- G.5. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide a summary of all logs used to demonstrate compliance with limitations and conditions of this section (ARM 17.8.1212).

H. EU007 – Platformer Unit

Platformer Heater, Platformer Debutanizer Reboiler Heater, Platformer Recycle Compressor Turbine

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
H.1, H.3, H.5, H.7, H.8	Opacity	20%	Method 9	As Required by the Department	Semi-annual
H.2, H.4, H.6, H.8	Equipment Leaks	Monitoring and Maintenance Plan	Log	During Performance of Program	Semi-annual

Conditions

- H.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).
- H.2. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart VV-Standards of Performance for Equipment Leaks of VOC in the Synthetic Organic Chemicals Manufacturing Industry. Subpart VV applies to the various pumps, valves, flanges, and other equipment in HAP service within the Platformer Unit (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.340; and 40 CFR 60, Subpart VV).

Compliance Demonstration

- H.3. Compliance with the opacity limitation listed in Section III.H.1 shall be determined using EPA reference Method 9 testing as required by the Department in accordance with Section III.A.1 (ARM 17.8.1213).
- H.4. Cenex shall institute the monitoring and maintenance plan in accordance with 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

- H.5. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

H.6. Recordkeeping for equipment leaks shall be performed in accordance with 40 CFR 63.648, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

H.7. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

H.8. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

- a. A summary of all logs used to demonstrate compliance with limitations and conditions of this section; and
- b. Certification of compliance with 40 CFR 63, Subpart CC.

I. EU008 – Fluid Catalytic Cracking (FCC) Unit

FCC Feed Preheater, FCC CO Boiler and FCC Regenerator

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
I.1, I.12, I.24, I.28, I.33	Opacity	40%	Method 9	As Required by the Department	Semi-annual
I.2, I.13, I.25, I.31, I.33	SO ₂ from old SWS	290.9 ton/year	Engineering Calculation	Annually	Monthly and Quarterly
I.3, I.13, I.25, I.31, I.33	NO _x from old SWS	107.9 ton/year	Engineering Calculation	Annually	Monthly
I.4, I.14, I.30, I.33	Continuous Flow Rate Monitor (sour water flow to old SWS)	Must be Equipped with Continuous Flow Rate Monitor	Log	Monthly	Quarterly
I.5, I.15, I.23, I.31, I.33	Sour Water Stripper Overheads	Burned in Main Crude Heater or Flare not to Exceed 55 Days/year or 65 Days for Any 2 Consecutive Years	Log	As needed	Quarterly
I.6, I.16, I.17, I.32, I.33	SO ₂	2,142.3 lb/ 3-hour Period	CEMS	Ongoing	Quarterly
			Method 6/6c	Annually	
I.7, I.16, I.17, I.32, I.33	SO ₂	17,138.4 lb/ Calendar Day	CEMS	Ongoing	Quarterly
			Method 6/6c	Annually	
I.8, I.16, I.17, I.32, I.33	SO ₂	6,255,516 lb/ Calendar Year	CEMS	Ongoing	Quarterly
			Method 6/6c	Annually	
I.9, I.15, I.18, I.19, I.23, I.26, I.29, I.30, I.32, I.33	FCC Regenerator/CO Boiler CEMS	Must be Equipped with CEMS	RATA	Annually	Quarterly
I.10, I.20, I.21, I.32, I.33	Continuous Stack Flow Rate Monitors (on the FCC Regenerator/CO Boiler stack)	Must be Equipped with Continuous Stack Flow Rate Monitors	Log	Monthly	Quarterly
I.11, I.22, I.27, I.33	Equipment Leaks	Monitoring and Maintenance Plan	Log	During Performance of Program	Semi-annual

Conditions

- I.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).
- I.2. SO₂ emissions attributed to the old Sour Water Stripper (SWS) shall not exceed 290.9 tons per year based on a rolling 12 calendar-month total (ARM 17.8.710).
- I.3. NO_x emissions attributed to the old SWS shall not exceed 107.9 tons per year based on a rolling 12 calendar-month total (ARM 17.8.710).
- I.4. Before SWSOH may be burned in the Main Crude Heater or the Refinery Flare, Cenex shall install, operate and maintain a continuous flow rate monitor to determine the sour water flow rate to the "old" SWS tower (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.5. Such periods in which the SWSOH are burned in the Main Crude Heater or the flare cannot exceed 55 days per calendar year and 65 days for any 2 consecutive calendar years (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.6. Cenex shall not cause or authorize total SO₂ emissions from the FCC regenerator stack to exceed the limit of 2,142.3 pounds per 3-hour period (Board of Environmental Review Order signed on June 12, 1998, this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.7. Cenex shall not cause or authorize total SO₂ emissions from the FCC Regenerator stack to exceed the limit of 17,138.4 pounds per calendar day (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.8. Cenex shall not cause or authorize total SO₂ emissions from the FCC Regenerator stack to exceed the limit of 6,255,516 pounds per calendar year (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.9. Cenex shall operate and maintain continuous emission monitors to measure SO₂ from the FCC Regenerator/CO Boiler stack (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

- I.10. Cenex shall operate and maintain continuous stack flow rate monitors to measure the stack gas flow rates from the FCC Regenerator/CO Boiler stack (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.11. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart VV-Standards of Performance for Equipment Leaks of VOC in the Synthetic Organic Chemicals Manufacturing Industry. Subpart VV applies to the various pumps, valves, flanges, and other equipment in HAP service within the FCC Unit (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.340; 40 CFR 60, Subpart VV).

Compliance Demonstration

- I.12. Compliance with the opacity limitation listed in Section III.I.1 shall be determined using EPA reference Method 9 testing, as required by the Department, in accordance with Section III.A.1 (ARM 17.8.1213).
- I.13. Emissions of NO_x and SO₂ attributed to the old SWS for determining compliance with the emission limits in Section III.I.1 and 2 shall be determined by twice-weekly measurements of hydrogen sulfide and ammonia in the old SWS feed stream and in the "stripper bottoms." The chemical analyses frequency for the old SWS unit, when operated, shall be twice per 7 days of continuous operation or, at least once if operated less than 3 days. Flow meters shall be utilized to establish the feed and "bottoms" flow rates. Emissions of SO₂ and NO_x, attributed to the old SWS, shall be determined by applying these measurements in engineering calculations according to the procedures described in Attachment A of Permit #1821-05. Reporting of the SO₂ and NO_x emissions data shall be in accordance with Section III.I.31 (ARM 17.8.710).
- I.14. Accuracy determinations for the sour water flow rate monitor shall be conducted every 48 months and within 3 months prior to any scheduled shutdown of the FCC CO Boiler which coincides with the scheduled operation of the "old" SWS. Accuracy determinations for the sour water flow rate monitor shall be conducted in accordance with Attachment #2 of the Stipulation or another method approved by the Department and EPA (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.15. Non-operation of the old SWS shall be verified by physically chaining and locking the old SWS feed valve in a closed position. A signed operator log shall be maintained to verify locking and unlocking of the feed water valve and days when the SWSOH are burned in the Main Crude Heater or the Refinery Flare (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.16. Compliance with the SO₂ emission limitations contained in Section III.I.6, 7, and 8 shall be determined using data from the CEMS required by Exhibit A, Section 6(B)(1) and (2) and in accordance with the appropriate equation(s) in Exhibit A, Section 2(A)(1), (7), (9), and (14), except when CEMS data is not available as provided in Exhibit A, Section 2(A)(14) of the Stipulation (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

- I.17. All gaseous (SO₂ and H₂S) continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR Part 60, Appendix F and operated in accordance with the performance specifications in 40 CFR Part 60, Appendix B, Performance Specification 2 and 7 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.18. For the FCC Regenerator/CO boiler stack CEMS, said CEMS shall be required to be maintained such that it is available and operating at least 90% of the source operating time during any reporting period (quarterly) (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.19. In order to certify the sulfur dioxide emission rates in pounds per hour for the FCC Regenerator/CO boiler stack, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6c as appropriate for the Stipulation and Exhibit A) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 of this permit (ARM 17.8.106). The annual Relative Accuracy Test Audits (RATAs) required by Exhibit A, Sections 6(C) and (D) of the Stipulation may substitute for the annual source tests provided that the flow rate RATA and the concentration RATA are performed simultaneously and additional calculations are made to determine and report the data in pounds per hour of sulfur dioxide (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.20. All continuous stack gas flow rate monitors required by the Stipulation shall be installed, certified (on a flow rate basis), and operated in accordance with Department Method A-1 of Attachment # 1 and be subject to and meet (on a flow rate basis) the quality assurance and quality control requirements of Department Method B-1 of Attachment # 1 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.21. CEM systems are to be in operation at all times when the emission units are operating, except for quality assurance and control checks, breakdowns and repairs. Startup and shut down for the FCC Regenerator/CO Boiler stack shall only include time periods when gas-oil feedstock is being delivered to the FCC. In the event the primary CEM system is unable to meet minimum availability requirements, the recipient shall provide a back-up or alternative monitoring system and plan such that continuous compliance can be demonstrated (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.22. Cenex shall institute the monitoring and maintenance plan in accordance with 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

- I.23. A signed operator log shall be maintained to verify locking and unlocking of the feed water valve and days when the SWSOH are burned in the Main Crude Heater or the Refinery Flare. Copies of this log shall be submitted to the Department as part of the quarterly emissions report specified in Section III.I.32 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.24. Cenex shall perform all source test recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).
- I.25. Recordkeeping compiled for purposes of demonstrating compliance with emission limitations shall be retained by Cenex for a minimum of 5 years (ARM 17.8.1212).
- I.26. CEMS data shall be recorded by a data collections system and shall be maintained by Cenex under Cenex's control for at least 5 years after the date of data generation. This electronic data shall be made available to Department personnel upon request and shall be submitted to the Department upon request (ARM 17.8.1212).
- I.27. Recordkeeping for equipment leaks shall be performed in accordance with 40 CFR 63.648, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

- I.28. Cenex shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).
- I.29. Cenex shall notify the Department in writing of each annual source test a minimum of 25 working days prior to the actual testing, unless otherwise specified by the Department (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.30. Cenex shall notify the Department in writing of each RATA a minimum of 25 working days prior to the actual testing, unless otherwise specified by the Department (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.31. Cenex shall submit monthly emission reports to the Department based on data from the installed CEMS/CERMS. Emission reporting for sulfur dioxide from the emission rate monitor shall consist of a daily 24-hour average (lb/hr) and a 24-hour total (lb/day) for each calendar day. Cenex shall submit the monthly emission reports within 30 days of the end of each calendar month. Copies of the monthly emission reports shall be submitted to both the Billings regional office and the Helena office of the Department. The monthly report shall also include the following (ARM 17.8.710):
 - a. Monitoring downtime that occurred during the reporting period.
 - b. Emission rate determinations for SO₂ and NO_x from the operation of the old SWS unit reported as a rolling 12 calendar-month total. Analysis results of ammonia and hydrogen sulfide concentrations for both the feed and bottoms. Copies of the operator log for the old SWS feed valve shall be submitted monthly.

- I.32. In accordance with Section 7 of the Stipulation (Appendix F of this permit), Cenex shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance Division office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- I.33. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):
- A summary of results of the last source testing that was performed;
 - Verification of compliance with unit emission limitations and conditions of this section;
 - A summary of all logs used to demonstrate compliance with limitations and conditions of this section;
 - Verification of compliance with Stipulation limits and that quarterly reports were submitted as required by Section III.I.32; and
 - Certification of compliance with 40 CFR 63, Subpart CC.

J. EU009 – Alkylation/Butamer/Merox Units

Alkylation Unit Hot Oil Belt Heater, Miscellaneous Process Vents (Alkylation Unit Butamer Stabilizer Offgas)

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirement
			Method	Frequency	
J.1, J.4, J.7, J.10, J.11	H ₂ S	0.10 grains/dscf	Method 11	Annual	Quarterly
J.2, J.5, J.8, J.11	Miscellaneous Process Vents	40 CFR 63.643	40 CFR 63.644 & 645	40 CFR 63.644 & 645	40 CFR 63.654
J.3, J.6, J.9, J.11	Equipment Leaks	Monitoring and Maintenance Plan	Log	During Performance of Program	Semi-annual

Conditions

- J.1. Hydrogen sulfide content of the fuel gas burned in the Alkylation Hot Oil Belt Heater shall not exceed 230 mg/dscm (0.10 grains/dscf) (ARM 17.8.340 and 40 CFR 60, Subpart J).
- J.2. Cenex shall comply with all applicable requirements of 40 CFR 63.643 as they apply to the units required to comply with the Miscellaneous Process Vents (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- J.3. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart VV-Standards of Performance for Equipment Leaks of VOC in the Synthetic Organic Chemicals Manufacturing Industry.

Subpart VV applies to the various pumps, valves, flanges, and other equipment in HAP service within the Alkylation Unit (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.340; and 40 CFR 60, Subpart VV).

Compliance Demonstration

- J.4. In order to accurately determine the hydrogen sulfide concentration in parts per million for the Alkylation Unit Hot Oil Belt Heater, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Method 11), or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106).
- J.5. Compliance demonstration for miscellaneous process vents shall be performed in accordance with 40 CFR 63.654, 63.644, and/or 63.645, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- J.6. Cenex shall institute the monitoring and maintenance plan in accordance with 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

- J.7. All source test recordkeeping shall be performed in accordance with the appropriate test method being used and Section III.A.1 (ARM 17.8.106).
- J.8. Recordkeeping for miscellaneous process vents shall be performed in accordance with 40 CFR 63.654, 63.644, and/or 63.645, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- J.9. Recordkeeping for equipment leaks shall be performed in accordance with 40 CFR 63.648, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

- J.10. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- J.11. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):
 - a. A summary of results of the last source testing that was performed;
 - b. A summary of all logs used to demonstrate compliance with limitations and conditions of this section;
 - c. Certification of compliance with 40 CFR 60, Subpart J; and
 - d. Certification of compliance with 40 CFR 63, Subpart CC.

K. EU010 – Hydrodesulfurization (HDS) Unit and Hydrogen Plant

Reformer heater (H-101), reactor charge heater stack (H-201), fractionator feed heater stack (H-202), and the hydrogen compressor gas engine (C-201B).

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
K.1, K.26, K.42, K.52	HDS Unit	40 CFR 60, Subpart J	Subpart J	Subpart J	Monthly and/or Quarterly
K.2, K.27, K.43, K.52	HDS Unit	40 CFR 60, Subpart GGG	Subpart VV	Subpart VV	
K.3, K.28, K.44, K.48, K.52	HDS Unit	40 CFR 60, Subpart QQQ	Subpart QQQ	Subpart QQQ	
K.4, K.29, K.45, K.49, K.52	Opacity	20%	Method 9	As Required by the Department	
K.5, K.30, K.34, K.45, K.46, K.49, K.50, K.52	NO _x from C-201B	30.43 Tons per Rolling 12 Calendar-Month Total and 7.14 lb/hr	Method 7	Annually	
K.6, K.30, K.34, K.45, K.46, K.49, K.50, K.52	CO from C-201B	68.59 Tons per Rolling 12 Calendar-Month Total, 6.40 lb/hr (firing natural gas), and 16.10 lbs/hr (firing propane)	Method 10	Annually	
K.7, K.34, K.46, K.50, K.52	VOC from C-201B	10.1 Tons per Rolling 12 Calendar-Month Total	Firing only natural gas	Ongoing	
			Method 18 (when firing propane fuel gas)	Annually	
K.8, K.35, K.46, K.50, K.52	C-201B	Combust Only Natural Gas or Propane	Verification	Ongoing	
K.9, K.34, K.45, K.48, K.49, K.50, K.52	SO ₂ from H-202	4.93 Tons per Rolling 12 Calendar-Month Total, and 1.24 lb/hr	Method 6/6c	Annually	
K.10, K.31, K.34, K.45, K.46, K.49, K.50, K.52	NO _x from H-202	8.34 tons per Rolling 12 Calendar-Month Total and 2.09 lb/hr	Method 7	Annually	
K.11, K.31, K.34, K.45, K.46, K.49, K.50, K.52	CO from H-202	6.42 Tons per Rolling 12 Calendar-Month Total and 1.61 lb/hr	Method 10	Annually	
K.12, K.34, K.46, K.50, K.52	VOC from H-202	0.51 Tons per Rolling 12 Calendar-Month Total	Firing Only Natural Gas	Ongoing	
			Method 18 (when firing refinery fuel gas)	Annually	
K.13, K.18, K.23, K.36, K.37, K.45, K.46, K.49, K.50, K.52	H ₂ S in fuel gas to H-202, H-201, H-101	0.10 grains/dscf	Method 11	As Required by the Department	
		Fuel Oil Cannot be Fired in These Units	Verification	Ongoing	
K.14, K.34, K.45, K.46, K.49, K.50, K.52	SO ₂ from H-201	6.83 Tons per Rolling 12 Calendar-Month Total and 1.72 lb/hr	Method 6/6c	Annually	
K.15, K.32, K.34, K.45, K.46, K.49, K.50, K.52	NO _x from H-201	11.56 Tons per Rolling 12 Calendar-Month Total and 2.9 lb/hr	Method 7	Annually	

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
K.16, K.32, K.34, K.46, K.49, K.52	CO from H-201	8.89 Tons per Rolling 12 Calendar-Month Total and 2.23 lb/hr	Method 10	Annually	
K.17, K.34, K.46, K.50, K.52	VOC from H-201	0.71 Tons per Rolling 12 Calendar-Month Total	Firing Only Natural Gas	Ongoing	
			Method 18 (when firing refinery fuel gas)	Annually	
K.19, K.34, K.45, K.46, K.49, K.50, K.52	SO ₂ from H-101	3.35 Tons per Rolling 12 Calendar-Month Total and 2.15 lb/hr	Method 6/6c	Annually	
K.20, K.33, K.34, K.45, K.46, K.49, K.50, K.52	NO _x from H-101	27.16 Tons per Rolling 12 Calendar- Month Total and 6.78 lb/hr	Method 7	Annually	
K.21, K.33, K.34, K.45, K.48, K.49, K.50, K.52	CO from H-101	13.93 Tons per Rolling 12 Calendar- Month Total and 4.51 lb/hr	Method 10	Annually	
K.22, K.34, K.46, K.50, K.52	VOC from H-101	0.35 Tons per Rolling 12 Calendar-Month Total	Firing Only Natural Gas	Ongoing	
			Method 18 (when firing refinery fuel gas)	Annually	
K.24, K.38, K.39, K.40, K.50, K.52	CEMS/CERMS	Operate and Maintain	40 CFR Part 60, Appendix F	Annually	
K.25, K.41, K.50, K.52	Continuous Fuel Gas Flow Rate Monitor	Operate and Maintain	Accuracy Determinations	At Least Once Every 48 Months	

Conditions

- K.1. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart J-Standards of Performance for Petroleum Refineries. These regulations shall apply to the Hydrodesulfurization (HDS) unit (including the Reformer Heater (H-101), Reactor Charge Heater stack (H-201), Fractionator Feed Heater stack (H-202), and the Hydrogen Compressor Gas Engine (C-201B)) and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart J).
- K.2. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart GGG-Equipment Leaks of VOC in Petroleum Refineries. These regulations shall apply to the HDS unit (including H-101, H-201, H-202, and C-201B) and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart GGG).
- K.3. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart QQQ-Standards of Performance for VOC Emissions from Petroleum Refinery Wastewater Systems. These regulations shall apply to the HDS unit (including the oily water collection system for the HDS complex, the HDS oil/water separator facilities including T-16, T-18, T-21, T-22 and T-23, the HDS cooling water collection system, and the HDS cooling water Pielkenroad) and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).

- K.4. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes. This applies to the sources in the HDS complex (ARM 17.8.304 (2)).
- K.5. NO_x emissions from C-201B shall not exceed 30.43 tons per rolling 12 calendar month total, and 7.14 lb/hr (ARM 17.8.710).
- K.6. CO emissions from C-201B shall not exceed 68.59 tons per rolling 12 calendar month total, 6.40 lb/hr when firing natural gas, and 16.10 lb/hr when firing propane (ARM 17.8.710).
- K.7. VOC emissions from C-201B shall not exceed 10.1 tons per rolling 12 calendar month total (ARM 17.8.710).
- K.8. Cenex shall only combust natural gas or propane in C-201B (ARM 17.8.710).
- K.9. SO₂ emissions from H-202 shall not exceed 4.93 tons per rolling 12 calendar month total, and 1.24 lb/hr (ARM 17.8.710).
- K.10. NO_x emissions from H-202 shall not exceed 8.34 tons per rolling 12 calendar month total and 2.09 lb/hr (ARM 17.8.710).
- K.11. CO emissions from H-202 shall not exceed 6.42 tons per rolling 12 calendar month total and 1.61 lb/hr (ARM 17.8.710).
- K.12. VOC emissions from H-202 shall not exceed 0.51 tons per rolling 12 calendar month total (ARM 17.8.710).
- K.13. Refinery fuel gas burned in H-202 shall not exceed 0.10 grains of H₂S per dry standard cubic foot. Cenex shall not combust fuel oil in this unit (ARM 17.8.710, ARM 17.8.340, and 40 CFR 60, Subpart J).
- K.14. SO₂ emissions from H-201 shall not exceed 6.83 tons per rolling 12 calendar month total and 1.72 lb/hr (ARM 17.8.710).
- K.15. NO_x emissions from H-201 shall not exceed 11.56 tons per rolling 12 calendar month total and 2.9 lb/hr (ARM 17.8.710).
- K.16. CO emissions from H-201 shall not exceed 8.89 tons per rolling 12 calendar month total and 2.23 lb/hr (ARM 17.8.710).
- K.17. VOC Emissions from H-201 shall not exceed 0.71 tons per rolling 12 calendar month total (ARM 17.8.710).
- K.18. Refinery fuel gas burned in H-201 shall not exceed 0.10 grains of H₂S per dry standard cubic foot. Cenex shall not combust fuel oil in this unit (ARM 17.8.710, ARM 17.8.340, and 40 CFR 60, Subpart J).

- K.19. SO₂ emissions from H-101 shall not exceed 3.35 tons per rolling 12 calendar month total and 2.15 lb/hr (ARM 17.8.710).
- K.20. NO_x emissions from H-101 shall not exceed 27.16 tons per rolling 12 calendar month total and 6.78 lb/hr (ARM 17.8.710).
- K.21. CO emissions from H-101 shall not exceed 13.93 tons per rolling 12 calendar month total and 4.51 lb/hr (ARM 17.8.710).
- K.22. VOC emissions from H-101 shall not exceed 0.35 tons per rolling 12 calendar month total (ARM 17.8.710).
- K.23. Refinery fuel gas burned in H-101 shall not exceed 0.10 grains of H₂S per dry standard cubic foot. Cenex shall not combust fuel oil in this unit (ARM 17.8.710, ARM 17.8.340, and 40 CFR 60, Subpart J).
- K.24. Cenex shall install and operate continuous emission monitors/continuous emission rate monitors (CEMS/CERMS) for H₂S in refinery fuel gas burned in the following combustion devices: H-202, H-201, and H-101 (ARM 17.8.710).
- K.25. Cenex shall operate and maintain a continuous fuel gas flow rate monitor downstream but adjacent to the amine unit fuel gas absorber for the refinery fuel gas system in the HDS complex (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

Compliance Demonstration

- K.26. Cenex shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR part 60, NSPS, Subpart J, Standards of Performance for Petroleum Refineries. These regulations shall apply to the HDS unit (including H-101, H-201, H-202, and C-201B) and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart J).
- K.27. Cenex shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR part 60, NSPS, Subpart GGG, Equipment Leaks of VOC in Petroleum Refineries. These regulations shall apply to the HDS unit (including H-101, H-201, H-202, and C-201B) and any other equipment, as appropriate. A monitoring and maintenance program, as described under New Source Performance Standards (40 CFR Part 60, Subpart VV), shall be instituted (ARM 17.8.340 and 40 CFR 60, Subpart GGG).
- K.28. Cenex shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR, part 60, NSPS, Subpart QQQ, Standards of Performance for Volatile Organic Compound Emissions from Petroleum Refinery Wastewater Systems. These regulations shall apply to the HDS unit and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).
- K.29. Compliance with the opacity limitation listed in Section III.K.4 shall be determined using EPA reference Method 9 testing as required by the Department (ARM 17.8.1213).

- K.30. The Superior Clean Burn II 12 SGIB (C201-B) compressor engine shall be tested annually, or according to another testing/monitoring schedule as may be approved by the Department, for NO_x and CO, concurrently (using Methods 7 and 10, respectively, in accordance with Section III.A.1 (ARM 17.8.106)), and the results submitted to the Department in order to demonstrate compliance with the NO_x and CO emission limits contained in Section III.K.5 and 6 (ARM 17.8.105 and ARM 17.8.710).
- K.31. The Fractionator Feed Heater Stack (H-202) shall be tested annually, or according to another testing/monitoring schedule as may be approved by the Department, for NO_x and CO, concurrently (using Methods 7 and 10, respectively, in accordance with Section III.A.1 (ARM 17.8.106)), and the results submitted to the Department in order to demonstrate compliance with the NO_x and CO emission limits contained in Section III.K.10 and 11 (ARM 17.8.105 and ARM 17.8.710).
- K.32. The Reactor Charge Heater Stack (H-201) shall be tested annually, or according to another testing/monitoring schedule as may be approved by the Department, for NO_x and CO, concurrently (using Methods 7 and 10, respectively, in accordance with Section III.A.1 (ARM 17.8.106)), and the results submitted to the Department in order to demonstrate compliance with the NO_x and CO emission limits contained in Section III.K.15 and 16 (ARM 17.8.105 and ARM 17.8.710).
- K.33. The Reformer Heater Stack (H-101) shall be tested annually, or according to another testing/monitoring schedule as may be approved by the Department, for NO_x and CO, concurrently (using Methods 7 and 10, respectively, in accordance with Section III.A.1 (ARM 17.8.106)), and the results submitted to the Department in order to demonstrate compliance with the emission limits contained in Section III.K.20 and 21 (ARM 17.8.105 and ARM 17.8.710).
- K.34. In addition to the testing required in Section III.K.30 through 33, compliance determinations for the emission limits applicable to the HDS complex sources listed in Sections III.K.6 through 23 shall be based upon actual fuel-burning rates and the emission factors developed from the most recent compliance source test. Fuel flow rates, fuel heating value, production information and other data, as needed, shall be recorded for each emitting unit during the performance of the source tests in order to develop emission factors for use in the compliance determinations. New emission factors shall become effective within 60 days after the completion of a source test. In order to accurately determine the sulfur dioxide emission rates in pounds per hour for the HDS complex sources, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6c) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106). Firing these units solely on natural gas shall demonstrate compliance with the applicable VOC limits. However, when refinery fuel gas is fired, the HDS complex sources shall be tested annually using Method 18 (ARM 17.8.710).
- K.35. Cenex shall demonstrate compliance with Section III.K.8 by verifying that only natural gas or propane have been combusted in C-201B (ARM 17.8.1213).

- K.36. In order to accurately determine the hydrogen sulfide concentration in parts per million, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Method 11) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106).
- K.37. Cenex shall demonstrate compliance with Section III.K.13, 18, and 23 by verifying that no fuel oil has been combusted in H-202, H-201, and H-101 (ARM 17.8.1213).
- K.38. CEMS and CERMS required by this permit shall comply with all applicable provisions of 40 CFR, Parts 60.5 through 60.13, Subparts J, 60.100-108 and Appendix B, Performance Specifications 2, 3, 6, and 7 and Appendix F; and 40 CFR 52, Appendix E, for certifying Volumetric Flow Rate Monitors (ARM 17.8.710).
- K.39. CEM systems are to be in operation at all times when the emission units are operating, except for quality assurance and control checks, breakdowns and repairs. Startup and shut down for the HDS Complex SRU Stack shall only include time periods when sulfur-bearing gases are being delivered to the HDS Complex SRU. In the event the primary CEM system is unable to meet minimum availability requirements, the recipient shall provide a back-up or alternative monitoring system and plan such that continuous compliance can be demonstrated (ARM 17.8.710).
- K.40. All gaseous (SO₂ and H₂S) continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR, Part 60, Appendix F, and operated in accordance with the performance specifications in 40 CFR, Part 60, Appendix B, Performance Specification 2 and 7 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- K.41. Refinery fuel gas flow rate monitor accuracy determinations shall be required at least once every 48 months or more frequently as routine refinery turn-arounds allow (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

Recordkeeping

- K.42. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart J (ARM 17.8.340 and 40 CFR 60, Subpart J).
- K.43. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart GGG (ARM 17.8.340 and 40 CFR 60, Subpart GGG).
- K.44. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart QQQ (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).
- K.45. Cenex shall perform all source test recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).
- K.46. All records compiled in accordance with this permit must be maintained by Cenex 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, the U.S. Environmental Protection Agency, and the Yellowstone County Air Pollution Control Agency, and must be submitted to the Department upon request (ARM 17.8.710).

K.47. No recordkeeping is required to verify exclusive use of propane and natural gas as required by Section III.K.8 or to verify non-use of fuel oil as required by Section III.K.13, 18, and 23 (ARM 17.8.1213).

Reporting

K.48. Cenex shall provide the Department copies of testing results, monitoring operations, recordkeeping, and report results as specified under 40 CFR 60, Subpart QQQ, Sections 60.693-2, 60.696, 60.697, and 60.698 (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).

K.49. Cenex shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).

K.50. Cenex shall submit monthly emission reports to the Department based on data from the installed CEMS/CERMS. Emission reporting for sulfur dioxide from the emission rate monitor shall consist of a daily 24-hour average (lb/hr) and a 24-hour total (lb/day) for each calendar day. Cenex shall submit the monthly emission reports within 30 days of the end of each calendar month. Copies of the monthly emission reports shall be submitted to both the Billings regional office and the Helena office of the Department. The monthly report shall also include the following (ARM 17.8.710):

- a. Source or unit operating time during the reporting period and monthly fuel gas consumption rates and 24-hour (daily) average concentration of H₂S in the refinery fuel gas burned at the permitted facilities.
- b. Monitoring downtime that occurred during the reporting period.
- c. A summary of excess emissions or applicable concentrations for each pollutant and the averaging period identified in Section III.K.5 through 23.
- d. Compliance determinations for hourly, 24-hour and annual limits specifically allowed in Section III.K.5 through 23 (ARM 17.8.710).
- e. Reasons for any emissions in excess of those specifically allowed in Section III.K.5 through 23 with mitigative measures utilized and corrective actions taken to prevent a recurrence of the situation.

K.51. In accordance with Section 7 of the Stipulation (Appendix F of this permit) Cenex shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance Division office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

K.52. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

- a. Verification that compliance with 40 CFR 60, Subpart J was maintained;

- b. Verification that compliance with 40 CFR 60, Subpart GGG was maintained;
- c. Verification that compliance with 40 CFR 60, Subpart QQQ was maintained;
- d. A summary of results of the last source testing that was performed;
- e. Verification of compliance with unit emission limits and conditions of this section and that monthly reports were submitted as required by Section III.K.55;
- f. A summary of all logs used to demonstrate compliance with limitations and conditions of this section; and
- g. Verification of compliance with Stipulation limits and that quarterly reports were submitted as required by Section III.K.51.

L. EU011 – Sulfur Recovery Unit (SRU - New)

Sulfur recovery unit reheater (E-407) and incinerator (INC-401)

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
L.1, L.13, L.28, L.37	SRU-New	40 CFR 60, Subpart J	Subpart J	Subpart J	Monthly and/or Quarterly
L.2, L.14, L.18, L.20, L.29, L.30, L.31, L.32, L.35, L.37	SO ₂	53.17 Tons per Rolling 12 Calendar-Month Total, 341.04 lb/day, and 14.21 lb/hr	Method 6/6c	Annually	
L.3, L.14, L.20, L.29, L.30, L.31, L.32, L.35, L.37	NO _x	3.5 Tons per Rolling 12 Calendar-Month Total, 19.2 lb/day, and 0.8 lb/hr	Method 7	Annually	
L.4, L.15, L.16, L.20, L.29, L.32, L.30, L.31, L.35, L.37	H ₂ S	0.10 grains/dscf	Method 11	Annually	
		Fuel Oil Cannot Be Fired in This Unit	Verification	Ongoing	
L.5, L.17, L.28, L.31, L.37	Claus Unit - SO ₂	250 ppm by Volume	Subpart J	Subpart J	
L.6, L.18, L.21, L.22, L.31, L.35, L.37	SO ₂ , O ₂ , Flow Rate CEMS/CERMS	Operate and Maintain	40 CFR Part 60, Appendix F	Annually	
L.7, L.19, L.21, L.22, L.31, L.35, L.37	H ₂ S CEMS/CERMS	Operate and Maintain	40 CFR Part 60, Appendix F	Annually	
L.8, L.23, L.26, L.29, L.32, L.33, L.36, L.37	SO ₂	42.6 Pounds per 3-Hour Period	CEMS	Ongoing	
			Method 6/6c	Annually	
L.9, L.23, L.26, L.29, L.32, L.33, L.36, L.37	SO ₂	340.8 Pounds per Calendar Day	CEMS	Ongoing	
			Method 6/6c	Annually	
L.10, L.23, L.26, L.29, L.32, L.33, L.36, L.37	SO ₂	124,392 Pounds per Calendar Year	CEMS	Ongoing	
			Method 6/6c	Annually	
L.11, L.24, L.25, L.26, L.29, L.32, L.34, L.36, L.37	SO ₂ CEMS	Operate and Maintain	RATA	Annually	
L.12, L.27, L.29, L.32, L.34, L.36, L.37	Continuous Stack Flow Rate Monitors	Operate and Maintain	RATA	Annually	

Conditions

- L.1. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart J—Standards of Performance for Petroleum Refineries. These regulations shall apply to the SRU Incinerator Stack (E-407 and INC-401) and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart J).
- L.2. SO₂ emissions from E-407 and INC-401 shall not exceed 53.17 tons per rolling 12 calendar-month total, 341.04 lb/day, and 14.21 lb/hr (250 ppm, rolling 12-hour average corrected to 0% oxygen on a dry basis) (ARM 17.8.710).
- L.3. NO_x emissions from E-407 and INC-401 shall not exceed 3.5 tons per rolling 12 calendar-month total, 19.2 lb/day, and 0.8 lb/hr (ARM 17.8.710).
- L.4. Refinery fuel gas burned in E-407 and INC-401 shall not exceed 0.10 grains of H₂S per dry standard cubic foot. Cenex shall not fire fuel oil in this unit (ARM 17.8.710, ARM 17.8.340, and 40 CFR 60, Subpart J).
- L.5. Cenex shall not cause or authorize the discharge of any gases into the atmosphere from any Claus sulfur recovery plant containing in excess of, for an oxidation control system or a reduction control system followed by incineration (E-407 & INC-407), 250 ppm by volume (dry basis) of SO₂ at 0% excess air (ARM 17.8.710, ARM 17.8.340, and 40 CFR 60, Subpart J).
- L.6. Cenex shall operate and maintain continuous emission monitors/continuous emission rate monitors (CEMS/CERMS) on E-407 and INC-401 for sulfur dioxide, oxygen, and volumetric flow rate (ARM 17.8.710).
- L.7. Cenex shall operate and maintain continuous emission monitors/continuous emission rate monitors (CEMS/CERMS) for continuous concentration (dry basis) monitoring of H₂S in refinery fuel gas burned in the E-407 and INC-401 (ARM 17.8.710).
- L.8. Cenex shall not cause or authorize total SO₂ emissions from the HDS complex SRU stack to exceed the limit of 42.6 pounds per 3-hour period (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- L.9. Cenex shall not cause or authorize total SO₂ emissions from the SRU incinerator stack to exceed the limit of 340.8 pounds per calendar day (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- L.10. Cenex shall not cause or authorize total SO₂ emissions from the SRU incinerator stack to exceed the limit of 124,392 pounds per calendar year (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).

- L.11. Cenex shall operate and maintain continuous emission monitors to measure SO₂ from the HDS complex SRU stack (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- L.12. Cenex shall operate and maintain continuous stack flow rate monitors to measure the stack gas flow rates from the HDS complex SRU stack (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).

Compliance Demonstration

- L.13. Cenex shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR, part 60, NSPS, Subpart J, Standards of Performance for Petroleum Refineries. These regulations shall apply to new SRU and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart J).
- L.14. The SRU Incinerator Stack (E-407 & INC-401) shall be tested annually, or according to another testing/monitoring schedule as may be approved by the Department, for SO₂ and NO_x (using Methods 6/6c and 7, respectively, in accordance with Section III.A.1 (ARM 17.8.106)), and the results submitted to the Department in order to demonstrate compliance with the SO₂ and NO_x emission limits contained in Section III.L.2 and 3 (ARM 17.8.105 and ARM 17.8.710).
- L.15. In order to certify the hydrogen sulfide concentration in parts per million, Cenex shall perform annual source testing using EPA-approved methods (40 CFR, Part 60, Appendix A, Method 11) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106).
- L.16. Cenex shall demonstrate compliance with Section III.L.4 by verifying that no fuel oil has been combusted in E-407 and INC-401 (ARM 17.8.1213).
- L.17. Cenex shall comply with the test methods and monitoring requirements of 40 CFR 60.105 and 60.106 to demonstrate compliance with Section III.L.5 (ARM 17.8.340, and 40 CFR 60, Subpart J).
- L.18. Compliance determinations for hourly, 24-hour and annual SO₂ limits for the SRU Incinerator stack shall be based upon CEMS data utilized for SO₂ as required in Section III.L.6 (ARM 17.8.1213).
- L.19. Compliance determinations for SO₂ limits for the fuel gas-fired units within the HDS shall be based upon monitor data for H₂S, as required in Section III.L.6 and fuel-firing rates, if these units are fired on refinery fuel gas. Firing these units solely on natural gas shall demonstrate compliance with the applicable SO₂ limits (ARM 17.8.1213).
- L.20. In addition to the testing required in Section III.L.14, compliance determinations for the emission limits applicable to the HDS complex sources listed in Sections III.L.2, 3, and 4 shall be based upon actual fuel-burning rates and the emission factors developed from the most recent compliance source test. Fuel flow rates, fuel heating value, production information and other data, as needed, shall be recorded for each emitting unit during the

performance of the source tests in order to develop emission factors for use in the compliance determinations. New emission factors shall become effective within 60 days after the completion of a source test (ARM 17.8.710).

- L.21. CEMS and CERMS required by this permit shall comply with all applicable provisions of 40 CFR, Parts 60.5 through 60.13, Subparts J, 60.100-108 and Appendix B, Performance Specifications 2, 3, 6, and 7, and Appendix F; and 40 CFR 52, Appendix E, for certifying Volumetric Flow Rate Monitors (ARM 17.8.710).
- L.22. CEM systems are to be in operation at all times when the emission units are operating, except for quality assurance and control checks, breakdowns and repairs. Startup and shut down for the HDS Complex SRU Stack shall only include time periods when sulfur-bearing gases are being delivered to the HDS Complex SRU. In the event the primary CEM system is unable to meet minimum availability requirements, the recipient shall provide a back-up or alternative monitoring system and plan such that continuous compliance can be demonstrated (ARM 17.8.710).
- L.23. Compliance with the SO₂ emission limitations contained in Section III.L.8, 9 and 10 shall be determined using data from the CEMS required by Exhibit A, Section 6(B)(1) and (2) and in accordance with the appropriate equation(s) in Exhibit A, Section 2(A)(1), (7), (9), and (14) except when CEMS data is not available as provided in Exhibit A, Section 2(A)(14) of the Stipulation (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- L.24. All gaseous (SO₂ and H₂S) continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR, Part 60, Appendix F and operated in accordance with the performance specifications in 40 CFR, Part 60, Appendix B, Performance Specification 2 and 7 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- L.25. For the HDS complex SRU stack CEMS, said CEMS shall be required to be maintained such that it is available and operating at least 90% of the source operating time during any reporting period (quarterly) (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- L.26. In order to certify the sulfur dioxide emission rates in pounds per hour for the HDS complex SRU stack, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6c as appropriate for this Stipulation and Exhibit A) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 of this permit (ARM 17.8.106). The annual RATAs required by Sections 6(C) and (D) may substitute for the annual source tests provided that the flow rate RATA and the concentration RATA are performed simultaneously and additional calculations are made to determine and report the data in pounds per hour of sulfur dioxide (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

- L.27. All continuous stack gas flow rate monitors required by the Stipulation shall be installed, certified (on a flow-rate basis), and operated in accordance with Department Method A-1 of Attachment # 1 and be subject to and meet (on a flow-rate basis) the quality assurance and quality control requirements of Department Method B-1 of Attachment # 1 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

Recordkeeping

- L.28. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart J (ARM 17.8.340 and 40 CFR 60, Subpart J).
- L.29. Cenex shall perform all source test recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).
- L.30. Recordkeeping compiled for purposes of demonstrating compliance with emission limitations shall be retained by Cenex for a minimum of 5 years (ARM 17.8.1212).
- L.31. All records compiled in accordance with this permit must be maintained by Cenex 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, the U.S. Environmental Protection Agency, and the Yellowstone County Air Pollution Control Agency, and must be submitted to the Department upon request (ARM 17.8.710).

Reporting

- L.32. Cenex shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).
- L.33. Cenex shall notify the Department in writing of each annual source test a minimum of 25 working days prior to the actual testing, unless otherwise specified by the Department (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- L.34. Cenex shall notify the Department in writing of each RATA a minimum of 25 working days prior to the actual testing, unless otherwise specified by the Department (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- L.35. Cenex shall submit monthly emission reports to the Department based on data from the installed CEMS/CERMS. Emission reporting for sulfur dioxide from the emission rate monitor shall consist of a daily 24-hour average (lb/hr) and a 24-hour total (lb/day) for each calendar day. Cenex shall submit the monthly emission reports within 30 days of the end of each calendar month. Copies of the monthly emission reports shall be submitted to both the Billings regional office and the Helena office of the Department. The monthly report shall also include the following (ARM 17.8.710):
- a. Source or unit operating time during the reporting period and monthly fuel gas consumption rates and 24-hour (daily) average concentration of H₂S in the refinery fuel gas burned at the permitted facilities.

- b. Monitoring downtime that occurred during the reporting period.
- c. A summary of excess emissions or applicable concentrations for each pollutant and the averaging period identified in Section III.L.2, 3, and 4.
- d. Compliance determinations for hourly, 24-hour and annual limits specifically allowed in Section III.L.2, 3, and 4 (ARM 17.8.710).
- e. Reasons for any emissions in excess of those specifically allowed in Section III.L.2, 3, and 4 with mitigative measures utilized and corrective actions taken to prevent a recurrence of the situation.

L.36. In accordance with Section 7 of the Stipulation (Appendix F of this permit), Cenex shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance Division office in Helena and the Billings Regional office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

L.37. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

- a. Verification that compliance with 40 CFR 60, Subpart J, was maintained;
- b. A summary of results of the last source testing that was performed;
- c. Verification of compliance with unit emission limits and conditions of this section and that monthly reports were submitted as required by Section III.L.35; and
- d. Verification of compliance with Stipulation limits and that quarterly reports were submitted as required by Section III.L.36.

M. EU012 – Sulfur Recovery Unit (SRU - Old)

Sulfur Recovery Unit Incinerator, Tail Gas Oxidizer Stack, #1 Sulfur Recovery Unit, #2 Sulfur Recovery Unit

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
M.1, M.10, M.18, M.20, M.21, M.23, M.24	SO ₂	2,916.3 lb/ 3-Hour Period	CEMS	Ongoing	Quarterly
			Method 6/6c	Annually	
M.2, M.10, M.13, M.18, M.20, M.21, M.23, M.24	SO ₂	23,330.4 lb/ Calendar Day	CEMS	Ongoing	
			Method 6/6c	Annually	
M.3, M.10, M.18, M.20, M.21, M.23, M.24	SO ₂	8,515,596 lb/ Calendar Year	CEMS	Ongoing	
			Method 6/6c	Annually	

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Frequency	Reporting Requirements
M.4, M.10, M.11, M.12, M.13, M.18, M.22, M.23, M.24	SO ₂ CEMS	Operate and Maintain	RATA	Annually	
M.5, M.14, M.23, M.24	Stack Flow Rate Monitors	Operate and Maintain	RATA	Annually	
M.6, M.11, M.23, M.24	H ₂ S Concentration Monitor	Operate and Maintain	40 CFR Part 60, Appendix F	Annually	
M.7, M.15, M.23, M.24	Continuous Fuel Gas Flow Rate Monitor	Operate and Maintain	Accuracy Determinations	At Least Once Every 48 Months	
M.8, M.16, M.19, M.24	SRU	Maximum Sulfur Production Rates	Verification	Ongoing	
M.9, M.17, M.18, M.20, M.21, M.24	Process Weight	$E = 4.10 * P^{0.67}$ or $E = 55 * P^{0.11} - 40$	Method 5	As Required by the Department	Semi-annual

Conditions

- M.1. Cenex shall not cause or authorize total SO₂ emissions from the old SRU Tail Gas Oxidizer stack exceed the limit of 2,916.3 pounds per 3-hour period (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- M.2. Cenex shall not cause or authorize total SO₂ emissions from the old SRU Tail Gas Oxidizer stack exceed the limit of 23,330.4 pounds per calendar day (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- M.3. Cenex shall not cause or authorize total SO₂ emissions from the old SRU Tail Gas Oxidizer stack to exceed the limit of 8,515,596 pounds per calendar year (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- M.4. Cenex shall operate and maintain continuous emission monitors to measure SO₂ from the old SRU Tail Gas Oxidizer stack (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- M.5. Cenex shall operate and maintain continuous stack flow rate monitors to measure the stack gas flow rates from the old SRU Tail Gas Oxidizer stack (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).
- M.6. Cenex shall operate and maintain an H₂S concentration monitor downstream but adjacent to the Zone A amine unit fuel gas absorber for the refinery fuel gas system in the refinery section. Within 4 hours of the initial determination that the H₂S concentration in the fuel gas stream has exceeded the upper range of the Zone A CEMS required by this paragraph, Cenex shall initiate sampling of the Zone A fuel gas stream on a once-per-3-hour-period frequency using the Tutwiler method (40 CFR 60.648), or another method approved by the Department and EPA to determine the H₂S concentration (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).

- M.7. Cenex shall operate and maintain a continuous fuel gas flow rate monitor downstream but adjacent to the Zone A amine unit fuel gas absorber for the refinery fuel gas system in the refinery section (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.8. The old SRU should be operated at the maximum sulfur production rate consistent with the availability of sulfur-containing feedstock streams and sour gas streams shall not be bypassed around this plant except for justifiable conditions such as an emergency or a malfunction (ARM 17.8.710).
- M.9. The particulate emission rate shall not exceed that specified by rule. Process weight shall include the three sour gas streams into the absorber section of the plant. Combustion air and liquid gaseous fuels to heaters or tail gas incineration will not be included (ARM 17.8.710).

Compliance Demonstration

- M.10. Cenex shall operate and maintain continuous emission monitors to measure SO₂ from the old SRU Tail Gas Oxidizer stack. Compliance with the emission limitations contained in Section III.M.1, 2 and 3 shall be determined using data from the CEMS required by Exhibit A, Section 6(B)(1) and (2) and in accordance with the appropriate equation(s) in Exhibit A, Section 2(A)(1), (7), (9), and (14) except when CEMS data is not available as provided in Exhibit A, Section 2(A)(14) of the Stipulation (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.11. All gaseous (SO₂ and H₂S) continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR, Part 60, Appendix F and operated in accordance with the performance specifications in 40 CFR, Part 60, Appendix B, Performance Specification 2 and 7 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.12. For the old SRU tail gas oxidizer stack CEMS, said CEMS shall be required to be maintained such that it is available and operating at least 90% of the source operating time during any reporting period (quarterly) (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.13. In order to accurately determine the sulfur dioxide emission rates in pounds per hour for the old SRU Tail Gas Oxidizer stack, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6c as appropriate for this Stipulation and Exhibit A), or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 of this permit (ARM 17.8.106). The annual RATAs required by Sections 6(C) and (D) may substitute for the annual source tests provided that the flow rate RATA and the concentration RATA are performed simultaneously and additional calculations are made to determine and report the data in pounds per hour of sulfur dioxide (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

- M.14. All continuous stack gas flow rate monitors required by the Stipulation shall be installed, certified (on a flow rate basis), and operated in accordance with Department Method A-1 of Attachment # 1 and be subject to and meet (on a flow rate basis) the quality assurance and quality control requirements of Department Method B-1 of Attachment # 1 (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.15. Refinery fuel gas flow rate monitor accuracy determinations shall be required at least once every 48 months or more frequently as routine refinery turn-arounds allow (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.16. Cenex shall demonstrate compliance with Section III.M.8 by verifying that old SRU is being operated at the maximum sulfur production rate consistent with the availability of sulfur-containing feedstock streams and sour gas streams are not bypassed around this plant except for justifiable conditions such as an emergency or a malfunction (ARM 17.8.1213).
- M.17. Compliance with Section III.M.9 shall be determined according to 40 CFR, Part 60, Appendix A, Method 5, as required by the Department (ARM 17.8.1213).

Recordkeeping

- M.18. Cenex shall perform all source test recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).
- M.19. No recordkeeping is required to verify that old SRU is being operated at the maximum sulfur production rate consistent with the availability of sulfur-containing feedstock streams and sour gas streams are not bypassed around this plant except for justifiable conditions such as an emergency or a malfunction as required by Section III.M.8 (ARM 17.8.1212).

Reporting

- M.20. Cenex shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).
- M.21. Cenex shall notify the Department in writing of each annual source test a minimum of 25 working days prior to the actual testing, unless otherwise specified by the Department (Board of Environmental Review Order signed on June 12, 1998, this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.22. Cenex shall notify the Department in writing of each RATA a minimum of 25 working days prior to the actual testing, unless otherwise specified by the Department (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- M.23. In accordance with Section 7 of the Stipulation (Appendix F of this permit), Cenex shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance

Division office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency).

M.24. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

- a. A summary of results of the last source testing that was performed; and
- b. Verification of compliance with Stipulation limits and that quarterly reports were submitted as required by Section III.M.23.

N. EU013 – Steam Generation Units

#3 Boiler, #4 Boiler, #5 Boiler, #9 Boiler, #10 Boiler, #1 Fuel Oil Heater, #2 Fuel Oil Heater

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
N.1, N.16, N.30, N.41, N.42	#10 Boiler	40 CFR 60, Subpart Dc	Subpart Dc	Subpart Dc	Monthly and/or Quarterly
N.2, N.17, N.31, N.42	#10 Boiler	40 CFR 60, Subpart J	Subpart J	Subpart J	
N.3, N.18, N.32, N.42	#10 Boiler	40 CFR 60, Subpart GGG	Subpart GGG	Subpart GGG	Semi-annual
N.4, N.19, N.33, N.36, N.42	H ₂ S #9 Boiler	0.10 grain/dscf	Method 11	Annually	Quarterly and/or Annually
N.5, N.19, N.20, N.33, N.34, N.36, N.37, N.38, N.39, N.42	H ₂ S #10 Boiler	0.10 grain/dscf	Method 11	Annually	Monthly and/or Quarterly
		Fuel Oil Cannot be Fired in #10 Boiler	Verify	Ongoing	
N.6, N.21, N.23, N.37, N.38, N.39, N.42	SO ₂ #10 Boiler	3.83 lb/hour	CEMS	Ongoing	
N.7, N.22, N.23, N.25, N.33, N.36, N.37, N.38, N.39, N.42	NO _x #10 Boiler	0.058 lb/MMBtu Fired and 5.79 lb/hour	Method 7	Every 5 Years	
N.8, N.22, N.23, N.25, N.33, N.36, N.37, N.38, N.39, N.42	CO #10 Boiler	0.10 lb/MMBtu Fired and 9.99 lb/hour	Method 10	Every 5 Years	
N.9, N.22, N.23, N.25, N.37, N.38, N.39, N.42	VOC #10 Boiler	0.015 lb/MMBtu Fired and 1.50 lb/hour	Firing Only Natural Gas	Ongoing	
			Method 18 (when firing refinery fuel gas)	Every 5 Years	
N.10, N.26, N.33, N.36, N.37, N.38, N.39, N.42	Opacity #10 Boiler	20%	Method 9	As Required by the Department	

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements	
			Method	Frequency		
N.11, N.22, N.23, N.24, N.34, N.34, N.35, N.37, N.38, N.39, N.42	Heat input	99.90 MMBtu/hour (#10 Boiler only)	Verify/Calculation	As Required by the Department		
	Low NO _x burners	Operate and Maintain	Method 7	Every 5 Years		
	Stack height	75 Feet from Ground Level	Verify	Ongoing		
N.12, N.27, N.37, N.38, N.39, N.42	H ₂ S Concentration Monitor	Operate and Maintain	40 CFR Part 60, Appendix F	Annually		
N.13, N.28, N.37, N.38, N.39, N.42	Fuel Gas Flow Rate Meter	Operate and Maintain	Attachment C of Permit #1821-02	At Least Once Every 48 Months		Semi-annual
N.14, N.29, N.41, N.42	Two Fuel Oil Flowmeters	Operate and Maintain	Stipulation, Method C-1 of Attachment #1	Stipulation, Method C-1 of Attachment #1		Quarterly
N.15, N.26, N.33, N.36, N.42	Opacity #3, #4, #5 Boilers	40%	Method 9	As Required by the Department	Semi-annual	

Conditions

- N.1. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart Dc-Standards of Performance for Small Industrial-Commercial-Institutional Steam Generating Units. These regulations shall apply to the #10 Boiler and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart Dc).
- N.2. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart J-Standards of Performance for Petroleum Refineries. These regulations shall apply to the #10 Boiler and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart J).
- N.3. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart GGG-Equipment Leaks of VOC in Petroleum Refineries. These regulations shall apply to the #10 Boiler and any other equipment, as appropriate. A monitoring and maintenance program, as described under New Source Performance Standards (40 CFR Part 60, Subpart VV), shall be instituted (ARM 17.8.340 and 40 CFR 60, Subpart GGG).
- N.4. Hydrogen sulfide content of the fuel gas burned in the #9 Boiler shall not exceed 230 mg/dscm (0.10 grain/dscf) (ARM 17.8.340 and 40 CFR 60, Subpart J).
- N.5. The #10 Boiler shall be fired only on natural gas until November 1, 1997, at which time Cenex will be allowed to fire refinery fuel gas in the boiler. Hydrogen sulfide concentration in the refinery fuel gas burned in the #10 Boiler shall not exceed 0.10 gr/dscf. Fuel oil burning is not allowed in this unit (ARM 17.8.715, ARM 17.8.710, ARM 17.8.340, and 40 CFR 60, Subpart J).
- N.6. SO₂ emissions from the #10 Boiler shall not exceed 3.83 lb/hour (ARM 17.8.715).
- N.7. NO_x emissions from the #10 Boiler shall not exceed 0.058 lb/MMBtu fired and 5.79 lb/hour (ARM 17.8.715).

- N.8. CO emissions from the #10 Boiler shall not exceed 0.10 lb/MMBtu fired and 9.99 lb/hour (ARM 17.8.715).
- N.9. VOC emissions from the #10 Boiler shall not exceed 0.015 lb/MMBtu fired and 1.50 lb/hour (ARM 17.8.715).
- N.10. Opacity from the #10 Boiler shall not exceed 20%, averaged over any 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).
- N.11. The #10 Boiler shall not exceed 99.90 MMBtu/hour of heat input. The boiler shall be fitted with low NO_x burners with Flue Gas Recirculation (FGR) and have a minimum stack height of 75 feet above ground level (ARM 17.8.710, ARM 17.8.340, 40 CFR 60, Subpart Dc).
- N.12. Cenex shall operate and maintain a continuous H₂S concentration monitor, including a data acquisition system, to monitor and record the H₂S concentration of all refinery fuel gas burned in the #10 Boiler (ARM 17.8.340 and 40 CFR 60, Subpart J).
- N.13. Cenex shall operate and maintain a continuous fuel gas flow rate meter, including a data acquisition system, to monitor and record the fuel flow rate of all fuel gas burned in the #10 Boiler (ARM 17.8.710).
- N.14. Cenex shall operate and maintain two in-line fuel oil flowmeters on the fuel loop, one immediately before the fuel oil tank in use and one before the first fuel oil loop in use (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- N.15. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from the #3, #4, and #5 Boilers installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

Compliance Demonstration

- N.16. Cenex shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR, part 60, NSPS, Subpart Dc, Standards of Performance for Small Industrial-Commercial-Institutional Steam Generating Units. These regulations shall apply to the #10 Boiler and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart Dc).

- N.17. Cenex shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR, part 60, NSPS, Subpart J, Standards of Performance for Petroleum Refineries. These regulations shall apply to the #10 Boiler and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart J).
- N.18. Cenex shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR, part 60, NSPS, Subpart GGG, Equipment Leaks of VOC in Petroleum Refineries. These regulations shall apply to the #10 Boiler and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart GGG).
- N.19. In order to certify the hydrogen sulfide concentration in parts per million, Cenex shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Method 11), or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106).
- N.20. Cenex shall demonstrate compliance with Section III.N.5 by verifying that no fuel oil has been combusted in the #10 Boiler (ARM 17.8.1213).
- N.21. Compliance determinations for SO₂ and H₂S limits for the #10 Boiler shall be based upon continuous H₂S concentration monitor data and fuel gas flowmeter data as required in Section III.N.12 and N.13. This compliance method, using H₂S concentration monitors data and fuel gas flowmeter data, will apply to the #10 Boiler as of November 1, 1997 (ARM 17.8.710).
- N.22. The #10 Boiler shall be tested for NO_x, CO, and VOC concurrently (using Methods 7, 10, and 18 respectively, in accordance with Section III.A.1 (ARM 17.8.106)) at a minimum of every 5 years or another testing/monitoring schedule as may be approved by the Department, and shall be conducted for both natural gas and refinery fuel gas (ARM 17.8.105 and 106).
- N.23. Fuel flow rates, fuel heating value, production information and other data, as needed, shall be recorded during the performance of source tests in order to develop emission factors for use in the compliance determinations for the #10 Boiler (ARM 17.8.710).
- N.24. Cenex shall demonstrate compliance with Section III.N.11 by notifying the Department if the #10 Boiler stack differs from 75 feet above grade (ARM 17.8.1213).
- N.25. In addition to the testing required in Section III.N.21, compliance determinations for NO_x, CO, and VOC emission limits for the #10 Boiler shall be based upon actual fuel-burning rates and the emission factors developed from the most recent compliance source test of each fuel being combusted. New emission factors shall become effective within 60 days after the completion of a source test. Firing Boiler #10 solely on natural gas shall demonstrate compliance with the applicable VOC limits (ARM 17.8.710).
- N.26. Compliance with the opacity limitations shall be determined according to 40 CFR, Part 60, Appendix A, Method 9 Visual Determination of Opacity of Emissions from Stationary Sources as required by the Department (ARM 17.8.710).

- N.27. The continuous fuel gas flow rate meter for the #10 Boiler shall meet the following specifications (ARM 17.8.710):
- a. For each hour when the unit is combusting fuel, the flow of fuel combusted by the unit must be measured and recorded. The flow of fuel must be measured with an in-line fuel flowmeter and the data must be automatically recorded with a data acquisition and handling system.
 - b. Each fuel flowmeter used shall meet a flowmeter accuracy of 2% of the upper range value (i.e., maximum calibrated fuel flow rate), either by design or as calibrated and as measured under laboratory conditions by the manufacturer, by an independent laboratory, or by the owner or operator.
 - c. The fuel gas flow rate meter shall meet the Fuel Gas Flowmeter Calibration and Quality Assurance Procedures outlined in Attachment C of Permit #1821-02.
- N.28. The continuous H₂S concentration monitor for the #10 Boiler shall comply with all applicable provisions of 40 CFR Parts 60.5 through 60.13, Subparts J, Appendix B, Performance Specifications 6 and 7, and Appendix F (Quality Assurance/Quality Control) provisions (ARM 17.8.340 and 40 CFR 60, Subpart J).
- N.29. Fuel oil flow metering shall be maintained and analyzed according to the following specifications (Board of Environmental Review Order signed on June 12, 1998; this requirement is “State Only” until approval of the SIP by the U.S. Environmental Protection Agency):
- a. Cenex shall operate and maintain all fuel oil flowmeters required by this control plan in accordance with Method C-1 of Attachment #1 of the Stipulation.
 - b. Cenex shall conduct daily fuel oil sampling in accordance with Method C-1 of Attachment 1 of the Stipulation.
 - c. Cenex shall analyze all fuel oil samples collected, as required by Exhibit A, Section 6(F)(2), for sulfur content in accordance with Method C-1 of Attachment #1 of the Stipulation.
 - d. Each fuel oil flowmeter required by this Stipulation shall demonstrate a flowmeter accuracy of 2% of the upper range value (i.e. maximum calibrated flow rate) as measured under laboratory conditions by the manufacturer or by the owner or operator, and pursuant to the calibration procedures as specified by Method C-1 of Attachment #1 of the Stipulation.
 - e. Cenex shall archive a split (at least 200 cc) of each fuel oil sample collected as required by Exhibit A, Section 6(F)(2) in accordance with Method C-1 of Attachment #1 of the Stipulation.

Recordkeeping

- N.30. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart Dc (ARM 17.8.340 and 40 CFR 60, Subpart Dc).

- N.31. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart J (ARM 17.8.340 and 40 CFR 60, Subpart J).
- N.32. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart GGG (ARM 17.8.340 and 40 CFR 60, Subpart GGG).
- N.33. Cenex shall perform all source test recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).
- N.34. No recordkeeping is required to verify non-use of fuel oil as required by Section III.N.5 or to verify stack height as required by Section III.N.11 for the #10 Boiler (ARM 17.8.1212).
- N.35. Cenex shall maintain, under Cenex's control, all logs required for compliance demonstration, shall make all logs available to Department personnel during inspections, and shall submit the logs to the Department upon request (ARM 17.8.1212).

Reporting

- N.36. Cenex shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).
- N.37. Cenex shall provide monthly emission reports using data from continuous H₂S concentration monitors and fuel gas flowmeters. Reporting requirements shall be consistent with 40 CFR, Part 60, or as specified by the Department (ARM 17.8.340 and 40 CFR 60, Subpart J). The monthly report shall also include the following (ARM 17.8.710):
 - a. SO₂ emission data from the refinery fuel gas system continuous H₂S concentration monitor and continuous fuel gas flow rate meter required by Section III.N.12 and 13. The SO₂ emission rates shall be reported for the following averaging periods.
 - i. Average lb/hr per calendar day
 - ii. Total lb per calendar day
 - iii. Total tons per month
 - b. NO_x emission data from the continuous fuel gas flow rate meter and the emission factors developed from the most recent compliance source test required by Section III.N.13 and 21. The NO_x emission rates shall be reported for the following averaging periods.
 - i. Average lb/hr per calendar day
 - ii. Total lb per calendar day
 - iii. Total tons per month
 - c. The daily and monthly total fuel gas consumption used to calculate the emission rates for Boiler #10 shall be reported.

- d. Source or unit operating time during the reporting period and monthly refinery fuel gas and natural gas consumption rates and 24-hour (daily) average concentration of H₂S in the refinery fuel gas burned at the permitted facility.
 - e. Monitoring downtime that occurred during the reporting period.
 - f. An excess emissions summary, which shall include excess emissions (lb/hr) for each pollutant and excess H₂S concentrations (gr/dscf) identified in Sections III.N.5 through III.N.11.
 - g. Reasons for any emissions in excess of those specifically allowed in Sections III.N.5 through III.N.11 with mitigative measures utilized and corrective actions taken to prevent a recurrence of the situation.
- N.38. Cenex shall submit monthly emission reports required in Section III.N.38 within 30 days of the end of each calendar month (ARM 17.8.710).
- N.39. Copies of monthly emission reports, excess emissions, emission testing reports and other reports required in this emitting unit shall be submitted to both the Billings regional office and the Helena office of the Department (ARM 17.8.710).
- N.40. Cenex shall comply with the reporting and recordkeeping requirements in 40 CFR 60.7 and 40 CFR 60.48c (a, g, and i). The maximum design heat input capacity shall be based on the highest gross calorific value (GCV) of each fuel to be combusted in Boiler #10. Cenex shall submit certification from the boiler manufacturer of the maximum design heat input capacity for the installed boiler. This certification shall include all design criteria used in determining the maximum design heat input capacity and provide reasons why this rate could not be exceeded. The Department may require recordkeeping and reporting requirements to demonstrate, on a continuing basis, that this maximum heat input capacity value is not being exceeded at any time (ARM 17.8.710, ARM 17.8.340, and 40 CFR 60, Subpart Dc).
- N.41. In accordance with Section 7 of the Stipulation (Appendix F of this permit), Cenex shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance Division office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).
- N.42. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):
- a. Verification that compliance with 40 CFR 60, Subpart Dc was maintained;
 - b. Verification that compliance with 40 CFR 60, Subpart J was maintained;
 - c. Verification that compliance with 40 CFR 60, Subpart GGG was maintained;

- d. A summary of results of the last source testing that was performed; and
- e. Verification of compliance with unit emission limits and conditions of this section and that monthly reports were submitted as required by Section III.N.38 and 39;
- f. A summary of all logs used to demonstrate compliance with limitations and conditions of this section; and
- g. Verification of compliance with Stipulation limits and that quarterly reports were submitted as required by Section III.N.42.

O. EU014 – Tank Farm

MACT Group 1 Storage Vessels: Tanks 61, 70, 74, 75, 78, 82, 83, 93, 95, 100, 101, 102, 103, 108, 109, 110, 112

MACT Group 2 Storage Vessels: Tanks 2, 4, 6, 7, 9, 11, 12, 23 (being converted to floating roof to meet Group 1 criteria), 25, 28, 29, 41, 43, 44, 47, 52, 55, 56, 60, 62, 63, 64, 65, 66, 67, 68, 71, 73, 76, 77, 79, 80, 81, 85, 86, 87, 88, 89, 90, 91, 92, 94, 96, 97, 98, 99, 104, 105, 106, 107, 111, 113, 114, 115, 116, 117, 118 (Wastewater Treatment, meets Group 1 criteria), 119, 120, 121, 122, 601, BP-2

Other: Tanks 123, B-1, B-2, B-7, firetk 1, firetk 2, firetk 3, firetk 4, tank 60 heater, tank BP2 heater.

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
O.1, O.3, O.5, O.7	Group 1 Storage Vessels	40 CFR 63 Subpart CC	40 CFR 63.646	40 CFR 63.646	40 CFR 63.654
O.2, O.4, O.6, O.7	Equipment Leaks	Monitoring and Maintenance Plan	Log	During Performance of Program	Semi-annual

Conditions

- O.1. Cenex shall comply with all applicable requirements of 40 CFR 63, Subpart CC-National Emission Standards for Hazardous Air Pollutants from Petroleum Refineries. This subpart applies to, but is not limited to, all Group 1 Storage Vessels (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- O.2. Cenex shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart VV—Standards of Performance for Equipment Leaks of VOC in the Synthetic Organic Chemicals Manufacturing Industry. Subpart VV applies to the various pumps, valves, flanges, and other equipment in HAP service within the Tank Farm (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.340; and 40 CFR 60, Subpart VV).

Compliance Demonstration

- O.3. Cenex shall meet the requirements of all testing and procedures of 40 CFR 63, Subpart CC—National Emission Standards for Hazardous Air Pollutants from Petroleum Refineries. These regulations shall apply to the Tank Farm and any other equipment, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

O.4. Cenex shall institute the monitoring and maintenance plan in accordance with 40 CFR 60, Subpart VV (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

O.5. Cenex shall comply with the recordkeeping requirements of 40 CFR 63.646 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

O.6. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

- a. A summary of results of the last source testing that was performed;
- b. A summary of all logs used to demonstrate compliance with limitations and conditions of this section; and
- c. Compliance with 40 CFR 63, Subpart CC, was maintained.

P. EU015– Transfer Facilities

Asphalt Loading Heater #1, Asphalt Loading Heater #2, Pitch Flaker, #4 Cooling Tower, Product Loading Rack Vapor Combustion Unit (VCU)

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
P.1, P.9, P.19, P.23, P.24	Product Loading Rack and VCU	40 CFR 63, Subpart CC	Subpart CC	Subpart CC	Semi-annual
P.2, P.10, P.11, P.19, P.20, P.23, P.24	Product Loading Rack and VCU	Operate and Maintain as Listed	Subpart CC	Subpart CC	
		VCU Stack – 35 Feet Above Grade	Verify	Ongoing	
P.3, P.12, P.18, P.19, P.22, P.23, P.24	VOC	10 mg/L of Gasoline Loaded	40 CFR 63.425	Every 5 Years	
P.4, P.13, P.14, P.18, P.22, P.24	CO	10 mg/L of Gasoline Loaded	Method 10	As Required by the Department	
P.5, P.13, P.14, P.18, P.22, P.24	NO _x	4 mg/L of Gasoline Loaded	Method 7	As Required by the Department	
P.6, P.15, P.18, P.22, P.24	Opacity	20%	Method 9	As Required by the Department	
P.7, P.16, P.20, P.24	Device to Detect Presence of a Flame (VCU flare)	Operate and Maintain	Verify	Ongoing	
P.8, P.17, P.21, P.24	Equipment Leaks of VOC	40 CFR 60.482-1 through 60.482- 10	Log	During Performance of Maintenance Program	

Conditions

- P.1. Cenex shall comply with all applicable requirements of 40 CFR, Part 63, National Emission Standards for Hazardous Air Pollutants for Source Categories, Subpart CC- National Emission Standards for Hazardous Air Pollutants from Petroleum Refineries. These regulations shall apply to the product loading rack and vapor combustion unit and any other equipment, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- P.2. The product loading rack and vapor combustion unit shall be operated and maintained as follows:
- a. Cenex's product loading rack shall be equipped with a vapor collection system designed to collect the organic compound vapors displaced from cargo tanks during gasoline product loading (ARM 17.8.342 and 40 CFR 63, Subpart CC).
 - b. Cenex's collected vapors shall be routed to the VCU at all times. In the event the VCU is inoperable, Cenex may continue to load distillates, provided the Department is notified in accordance with the requirements of ARM 17.8.110 (ARM 17.8.710).
 - i. The vapor collection and liquid loading equipment shall be designed and operated to prevent gauge pressure in the gasoline cargo tank from exceeding 4,500 Pascals (Pa) (450 millimeters (mm) of water) during product loading. This level shall not be exceeded when measured by the procedures specified in the test methods and procedures in 40 CFR 60.503(d) (ARM 17.8.342 and 40 CFR 63, Subpart CC).
 - ii. No pressure-vacuum vent in the permitted terminal's vapor collection system shall begin to open at a system pressure less than 4,500 Pa (450 mm of water) (ARM 17.8.342 and 40 CFR 63, Subpart CC).
 - iii. The vapor collection system shall be designed to prevent any volatile organic compound (VOC) vapors collected at one loading rack from passing to another loading rack (ARM 17.8.342 and 40 CFR 63, Subpart CC).
 - iv. Loadings of liquid products into gasoline cargo tanks shall be limited to vapor-tight gasoline cargo tanks using the following procedures (ARM 17.8.342 and 40 CFR 63, Subpart CC):
 1. Cenex shall obtain annual vapor tightness documentation described in the test methods and procedures in 40 CFR 63.425(e) for each gasoline cargo tank that is to be loaded at the product loading rack.
 2. Cenex shall require the cargo tank identification number to be recorded as each gasoline cargo tank is loaded at the terminal.
 3. Cenex shall cross-check each tank identification number obtained during product loading with the file of tank vapor tightness documentation within 2 weeks after the corresponding cargo tank is loaded.

4. Cenex shall notify the owner or operator of each non-vapor-tight cargo tank loaded at the product loading rack within 3 weeks after the loading has occurred.
 5. Cenex shall take the necessary steps to ensure that any non-vapor-tight cargo tank will not be reloaded at the product loading rack until vapor tightness documentation for that cargo tank is obtained, which documents that:
 - aa. The gasoline cargo tank meets the applicable test requirements in 40 CFR 63.425(e) to this permit.
 - bb. For each gasoline cargo tank failing the test requirements in 40 CFR 63.425(f) or (g), the gasoline cargo tank must either:
 - i. Before the repair work is performed on the cargo tank, meet the test requirements in 40 CFR 63.425 (g) or (h), or
 - ii. After repair work is performed on the cargo tank before or during the tests in 40 CFR 63.425 (g) or (h), subsequently passes the annual certification test described in 40 CFR 63.425(e).
 - v. Cenex shall ensure that loadings of gasoline cargo tanks at the product loading rack are made only into cargo tanks equipped with vapor collection equipment that is compatible with the terminal's vapor collection system (ARM 17.8.342 and 40 CFR 63, Subpart CC).
 - vi. Cenex shall ensure that the terminal's and the cargo tank's vapor recovery systems are connected during each loading of a gasoline cargo tank at the product loading rack (ARM 17.8.342 and 40 CFR 63, Subpart CC).
 - vii. The VCU stack shall be 35 feet above grade (ARM 17.8.710).
- P.3. The total VOC emissions to the atmosphere from the VCU due to loading liquid product into cargo tanks shall not exceed 10.0 milligrams per liter (mg/L) of gasoline loaded (ARM 17.8.342; 40 CFR 63, Subpart R; and ARM 17.8.715).
- P.4. The total CO emissions to the atmosphere from the VCU due to loading liquid product into cargo tanks shall not exceed 10.0 milligrams per liter (mg/L) of gasoline loaded (ARM 17.8.715).
- P.5. The total NO_x emissions to the atmosphere from the VCU due to loading liquid product into cargo tanks shall not exceed 4.0 milligrams per liter (mg/L) of gasoline loaded (ARM 17.8.715).

- P.6. Cenex shall not cause or authorize to be discharged into the atmosphere from the enclosed VCU any visible emissions that exhibit an opacity of 20% or greater over any 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).
- P.7. Cenex shall continuously operate and maintain a thermocouple and an associated recorder, or an ultraviolet flame detector and relay system, which will render the loading rack inoperable if a flame is not present at the VCU flare tip, or any other equivalent device to detect the presence of a flame (ARM 17.8.342 and ARM 17.8.715).
- P.8. Cenex shall monitor and maintain all pumps, shutoff valves, relief valves and other piping and valves associated with the gasoline loading rack as described in 40 CFR 60.482-1 through 60.482-10 (ARM 17.8.710; ARM 17.8.342; 40 CFR 63 Subpart CC; ARM 17.8.340; and 40 CFR 60, Subpart VV).

Compliance Demonstration

- P.9. Cenex shall perform the testing and monitoring procedures specified in 40 CFR §§63.425 and 63.427 of subpart R, except §63.425(d) or §63.427(c) (ARM 17.8.342; 40 CFR 63, Subpart CC; and 40 CFR 63, Subpart R).
- P.10. Cenex shall comply with all test methods and procedures as specified by subpart R §63.425 (a) through (c), and §63.425 (e) through (h). This shall apply to, but not be limited to, the product loading rack, the vapor processing system, and all gasoline equipment located at the product loading rack (ARM 17.8.342; 40 CFR 63, Subpart CC; and 40 CFR 63, Subpart R).
- P.11. Cenex shall demonstrate compliance with Section III.P.2 by notifying the Department if the VCU stack differs from 35 feet above grade (ARM 17.8.1213).
- P.12. The product loading rack VCU shall be tested for VOCs, and compliance demonstrated with the emission limitation contained in Section III.P.3, on an every-5-year basis or another testing/monitoring schedule as may be approved by the Department. Cenex shall perform the test methods and procedures as specified in 40 CFR 63.425, Subpart R (ARM 17.8.105; ARM 17.8.342; 40 CFR 63, Subpart CC; and 40 CFR 63, Subpart R).
- P.13. The product loading rack VCU shall be initially tested for CO and NO_x, concurrently (using Methods 10 and 7 respectively, in accordance with Section III.A.1 (ARM 17.8.106)), and compliance demonstrated with the CO and NO_x emission limitations contained in Section III.P.4 and 5 as required by the Department (ARM 17.8.105).
- P.14. Fuel flow rates, production information, and any other data the Department believes is necessary shall be recorded during the performance of source tests (ARM 17.8.710).
- P.15. Compliance with the opacity limitation listed in Section III.P.6 shall be determined using EPA reference Method 9 testing by a qualified observer (ARM 17.8.1213).

- P.16. Cenex shall demonstrate compliance with Section III.P.7 by verifying that a thermocouple and an associated recorder, or an ultraviolet flame detector and relay system, which will render the loading rack inoperable if a flame is not present at the VCU flare tip, or any other equivalent device, is operating to detect the presence of a flame. (ARM 17.8.1213).
- P.17. Cenex shall maintain a log, under Cenex's control, of monitoring and maintenance activities on all pumps, shutoff valves, relief valves and other piping and valves associated with the gasoline loading rack as described in 40 CFR 60.482-1 through 60.482-10 (ARM 17.8.340 and 40 CFR 60, Subpart VV).

Recordkeeping

- P.18. All source test recordkeeping shall be performed in accordance with the appropriate test method being used and Section III.A.1 (ARM 17.8.106).
- P.19. Cenex shall keep records as required by 40 CFR, Part 63, National Emission Standards for Hazardous Air Pollutants (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- a. Subpart CC - Cenex shall keep all records as required by 40 CFR, Part 63.428 (b) and (c), (g)(1), and (h)(1) through (h)(3) of subpart R.
 - b. Subpart CC - Cenex shall keep all records as required by 40 CFR, Part 63.654.
- P.20. No recordkeeping is required to verify the VCU stack height as required by Section III.P.3 or to verify the existence of a device to detect the presence of a flame on the VCU flare as required by Section III.P.7 (ARM 17.8.1212).
- P.21. Cenex shall maintain, under Cenex's control, all logs required for compliance demonstration, shall make all logs available to Department personnel during inspections, and shall submit the logs to the Department upon request (ARM 17.8.1212).

Reporting

- P.22. Cenex shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).
- P.23. Cenex shall supply the Department with the following reports, as required by 40 CFR, Part 63, National Emission Standards for Hazardous Air Pollutants (ARM 17.8.342 and 40 CFR 63, Subpart CC).
- a. Subpart CC - Cenex shall furnish all reports to the Department as required by 40 CFR, Part 63.428 (b) and (c), (g)(1), and (h)(1) through (h)(3) of subpart R.
 - b. Subpart CC - Cenex shall furnish all reports to the Department as required by 40 CFR, Part 63.654.
- P.24. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):
- a. Compliance with 40 CFR 63, Subpart CC, was maintained;

- b. A summary of results of the last source testing that was performed;
- c. A summary of all logs used to demonstrate compliance with limitations and conditions of this section; and
- d. Verification of compliance with unit emission limits and conditions of this section.

Q. EU016 – Wastewater Treatment Units

Wastewater Treatment Unit (Old), Wastewater Treatment Unit (New), Tank 118 (Slop Oil Emulsions), Tank 23, Tank 25, Tank 119, Tank 601, Tank 44, and New Wastewater Treatment Unit Vessels

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
Q.1, Q.4, Q.7, Q.11	Wastewater Treatment	40 CFR 60, Subpart QQQ	Subpart QQQ	Subpart QQQ	Semi-annual
Q.2, Q.5, Q.8, Q.11	Wastewater Treatment	40 CFR 61, Subpart FF	Subpart FF	Subpart FF	
Q.3, Q.6, Q.9, Q.10, Q.11	Tank 118	40 CFR 60 Subpart Kb	40 CFR 60.113b and/or 40 CFR 60.114b	As Specified	

Conditions

- Q.1. Cenex shall comply with all requirements of 40 CFR 60, Subpart QQQ-Standards of Performance for VOC Emissions. This subpart applies to, but is not limited to the Wastewater Treatment Unit (New), and any other applicable equipment. All equipment shall be operated and maintained as required under 40 CFR, Part 60, Subpart QQQ (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).
- Q.2. Cenex shall comply with all requirements of 40 CFR 61, Subpart FF-National Emission Standard for Benzene Waste Operations. This subpart applies to, but is not limited to, the Wastewater Treatment Unit (Old) and the Wastewater Treatment Unit (New) (ARM 17.8.341 and 40 CFR 61, Subpart FF).
- Q.3. All volatile organic storage vessels (including petroleum liquid storage vessels) for which construction, reconstruction or modification commenced after July 23, 1984, shall comply with the requirements of 40 CFR 60, Subpart Kb. These requirements shall be as specified in 40 CFR 60.110b through 60.115b. The affected tanks include, but are not limited to, Tank 118 (ARM 17.8.340 and 40 CFR 60, Subpart Kb).

Compliance Demonstration

- Q.4. Cenex shall meet the requirements of all applicable testing and procedures of 40 CFR 60, Subpart QQQ-Standards of Performance for VOC Emissions. These regulations shall apply to the Wastewater Treatment Unit (New) and any other equipment, as appropriate (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).
- Q.5. Cenex shall meet the requirements of all applicable testing and procedures of 40 CFR 61, Subpart FF-National Emission Standard for Benzene Waste Operations. These regulations shall apply to the Wastewater Treatment Unit (Old) and the Wastewater Treatment Unit (New) and any other equipment, as appropriate (ARM 17.8.341 and 40 CFR 61, Subpart FF).

Q.6. Cenex shall demonstrate compliance with Section III.Q.3 by complying with 40 CFR 60.113b and/or 40 CFR 60.114b (ARM 17.8.340 and 40 CFR 60, Subpart Kb).

Recordkeeping

Q.7. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart QQQ (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).

Q.8. Cenex shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 61, Subpart FF (ARM 17.8.341 and 40 CFR 61, Subpart FF).

Q.9. Cenex shall maintain a log, under Cenex’s control, for the monitoring required by 40 CFR 60.115b and 40 CFR 60.116b (ARM 17.8.340 and 40 CFR 60, Subpart Kb).

Reporting

Q.10. Cenex shall submit reports in accordance with 40 CFR 60.115b (ARM 17.8.340 and 40 CFR 60, Subpart Kb).

Q.11. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

- a. A summary of reporting done to conform to requirements of 40 CFR 60, Subpart QQQ;
- b. A summary of reporting done to conform to requirements of 40 CFR 61, Subpart FF; and
- c. Verification that the testing procedures of 60.113b and/or 114b were followed.

R. EU017 – Flare System

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
R.1, R.2, R.3, R.4, R.5, R.6	SO ₂	Minor Flaring and 150 lbs/3-hr	Reporting & Corrective Action	As Necessary	At Least Quarterly and as Necessary

Conditions

R.1. Cenex shall not allow SO₂ emissions from any flare, unless the emissions are a minor flaring event, or are the result of start-up, shutdown, or a malfunction as defined in ARM 17.8.110. A minor flaring event means a flaring event that emits less than or equal to 150 pounds of SO₂ per 3-hour period (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only").

R.2. Except for minor flaring events, Cenex shall minimize SO₂ emissions from flaring. In addition, when flaring of sulfur bearing gases occurs due to a malfunction, Cenex shall take immediate action to correct the malfunction (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only").

Compliance Demonstration

R.3. For purposes of determining whether a flaring event greater than 150 pounds of SO₂ per 3-hour period has occurred, Cenex shall maintain records of all activities, other than de minimis activities, that result in SO₂ emissions from the flare (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only").

Recordkeeping

R.4. Cenex shall maintain a record of all flaring events. Each entry shall include the date; time; duration; an engineering estimate of the 3-hour emissions; the measured flow rate to the flare, if available; a description of the source and estimated equivalent sulfur content of the gases directed to the flare; a reason for the flaring event; a description of the immediate actions taken to correct the situation; and the operator's initials (Board of Environmental Review Order signed on June 12, 1998; this requirement is "State Only").

Reporting

R.5. For flaring events in excess of 150lbs/3-hr period, Cenex shall comply with the reporting requirements identified in Section (3)(A)(5) of Exhibit A-1 of the Stipulation (Board of Environmental Review Order Signed on June 12, 1998; this requirement is "State Only").

R.6. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide verification of compliance with Stipulation limits and that reports were submitted as required by Section III.R.5 (ARM 17.8.1212).

S. EU018 – RCRA Units

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
S.1, S.2, S.3, S.4, S.5	Opacity	20%	Method 9	As Required by the Department	Semi-annual

Conditions

S.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

Compliance Demonstration

S.2. Compliance with the opacity limitation listed in Section III.S.1 shall be determined using EPA reference Method 9 testing in accordance with Section III.A.1 by a qualified observer (ARM 17.8.1213).

Recordkeeping

S.3. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

- S.4. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- S.5. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide a summary of results of the last source testing that was performed (ARM 17.8.1212).

T. EU019 – Cooling Towers

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
T.1, T.2, T.3, T.4, T.5	Opacity	40%	Method 9	As Required by the Department	Semi-annual

Conditions

- T.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(1)).

Compliance Demonstration

- T.2. Compliance with the opacity limitation listed in Section III.T.1 shall be determined using EPA reference Method 9 testing as required by the Department in accordance with Section III.A.1 by a qualified observer (ARM 17.8.1213).

Recordkeeping

- T.3. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

- T.4. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- T.5. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide a summary of results of the last source testing that was performed (ARM 17.8.1212).

U. EU020 – Saturate Gas Concentration Unit

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
U.1, U.2, U.3, U.4, U.5	Opacity	20%	Method 9	As Required by the Department	Semi-annual

Conditions

- U.1. Cenex shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.304(2)).

Compliance Demonstration

- U.2. Compliance with the opacity limitation listed in Section III.U.1 shall be determined using EPA reference Method 9 testing as required by the Department in accordance with Section III.A.1 by a qualified observer (ARM 17.8.1213).

Recordkeeping

- U.3. All source test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

- U.4. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).
- U.5. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide a summary of results of the last source testing that was performed (ARM 17.8.1212).

SECTION IV. NON-APPLICABLE REQUIREMENTS

Air Quality Administrative Rules of Montana (ARM) and Federal Regulations identified as not applicable to the facility or to a specific emission unit at the time of the permit issuance are listed below (ARM 17.8.1214). The following list does not preclude the need to comply with any new requirements that may become applicable during the permit term.

A. Facility-Wide

The following table contains non-applicable requirements that are administrated by the Air and Waste Management Bureau of the Department of Environmental Quality.

Rule Citation	Reason
ARM 17.8.320, ARM 17.8.321, ARM 17.8.323, ARM 17.8.331, ARM 17.8.332, ARM 17.8.333, and ARM 17.8.334.	These rules are not applicable because the facility is not listed in the source category cited or does not have the specific emission unit(s) cited in the rules.
40 CFR 60 Subparts B, C, Ca, Cb 40 CFR 60 Subparts D, Da, Db 40 CFR 60 Subparts E-I, Ka 40 CFR 60 Subparts L-Z 40 CFR 60 Subparts AA-EE 40 CFR 60 Subparts GG-HH 40 CFR 60 Subparts KK-NN 40 CFR 60 Subparts PP-UU 40 CFR 60 Subparts WW 40 CFR 60 Subparts AAA- DDD 40 CFR 60 Subparts FFF 40 CFR 60 Subparts HHH-LLL 40 CFR 60 Subparts NNN-PPP 40 CFR 60 Subparts RRR-WWW 40 CFR 61 Subparts B-F 40 CFR 61 Subparts H-I 40 CFR 61 Subparts K-L 40 CFR 61 Subparts N-R 40 CFR 61 Subpart T 40 CFR 61 Subparts W 40 CFR 61 Subpart Y 40 CFR 61 Subpart BB	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 63 Subpart B 40 CFR 63 Subparts F-I 40 CFR 63 Subparts L-O 40 CFR 63 Subparts Q 40 CFR 63 Subpart S-Y 40 CFR 63 Subparts DD-EE 40 CFR 63 Subpart GG	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 82 Subparts A-E 40 CFR 82 Subparts G-H	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 72 through 40 CFR 78	These requirements are not applicable because the facility is not an affected source as defined by the acid rain regulations.

B. Emission Units

The permit application identified applicable requirements as well as non-applicable requirements. The Department has listed all non-applicable requirements in Section IV.A. These requirements relate to each specific unit as well as facility wide.

SECTION V. GENERAL PERMIT CONDITIONS

A. Compliance Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(a)-(c)&(e), §1206(6)(c)&(b)

1. The permittee must comply with all conditions of the permit. Any noncompliance with the terms or conditions of the permit constitutes a violation of the Montana Clean Air Act, and may result in enforcement action, permit modification, revocation and reissuance, or termination, or denial of a permit renewal application under ARM Title 17, Chapter 8, Subchapter 12.
2. The filing of a request by the permittee for a permit modification, revocation and reissuance, or termination, or of a notification of planned changes or anticipated noncompliance does not stay any permit condition.
3. It shall not be a defense for a permittee in an enforcement action that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of the permit. If appropriate, this factor may be considered as a mitigating factor in assessing a penalty for noncompliance with an applicable requirement if the source demonstrates that both the health, safety or environmental impacts of halting or reducing operations would be more serious than the impacts of continuing operations, and that such health, safety or environmental impacts were unforeseeable and could not have otherwise been avoided.
4. The permittee shall furnish to the Department, within a reasonable time set by the Department (not to be less than 15 days), any information that the Department may request in writing to determine whether cause exists for modifying, revoking and reissuing, or terminating the permit, or to determine compliance with the permit. Upon request, the permittee shall also furnish to the Department copies of those records that are required to be kept pursuant to the terms of the permit. This subsection does not impair or otherwise limit the right of the permittee to assert the confidentiality of the information requested by the Department, as provided in 75-2-105, MCA.
5. Any schedule of compliance for applicable requirements with which the source is not in compliance with at the time of permit issuance shall be supplemental to, and shall not sanction noncompliance with, the applicable requirements on which it was based.
6. For applicable requirements that will become effective during the permit term, the source shall meet such requirements on a timely basis unless a more detailed plan or schedule is required by the applicable requirement or the Department.

B. Certification Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1207 and §1213(7)(a)&(c)-(e)

1. Any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12, shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete.

2. Compliance certifications shall be submitted by January 31 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. Each certification must include the required information for the previous calendar year (i.e., January 1 – December 31).
3. Compliance certifications shall include the following:
 - a. The identification of each term or condition of the permit that is the basis of the certification;
 - b. The compliance status as shown by monitoring or other information required by the permit or otherwise reasonably available to the source;
 - c. Whether compliance was continuous or intermittent;
 - d. The method(s) used for determining the compliance status of the source, currently and over the reporting period, consistent with ARM 17.8.1212; and
 - e. Such other facts as the Department may require to determine the compliance status of the source.
4. All compliance certifications must be submitted to the Environmental Protection Agency, as well as to the Department, at the addresses listed in the Notification Addresses Appendix of this permit.

C. Permit Shield

ARM 17.8, Subchapter 12, Operating Permit Program §1214(1)-(4)

1. The applicable requirements and non-federally enforceable requirements are included and specifically identified in this permit and the permit includes a precise summary of the requirements not applicable to the source. Compliance with the conditions of the permit shall be deemed compliance with any applicable requirements and any non-federally enforceable requirements as of the date of permit issuance.
2. The permit shield described in 1 above shall remain in effect during the appeal of any permit action (renewal, revision, reopening, or revocation and reissuance) to the Board of Environmental Review (Board), until such time as the Board renders its final decision.
3. Nothing in this permit alters or affects the following:
 - a. The provisions of Sec. 7603 of the FCAA, including the authority of the administrator under that section.
 - b. The liability of an owner or operator of a source for any violation of applicable requirements prior to or at the time of permit issuance.
 - c. The applicable requirements of the Acid Rain Program, consistent with Sec. 7651g(a) of the FCAA.

- d. The ability of the administrator to obtain information from a source pursuant to Sec. 7414 of the FCAA.
 - e. The ability of the Department to obtain information from a source pursuant to the Montana Clean Air Act, Title 75, Chapter 2, MCA.
 - f. The emergency powers of the Department under the Montana Clean Air Act, Title 75, Chapter 2, MCA.
 - g. The ability of the Department to establish or revise requirements for the use of reasonably available control technology (RACT) as defined in ARM Title 17, Chapter 8. However, if the inclusion of a RACT into the permit pursuant to ARM Title 17, Chapter 8, Subchapter 12, is appealed to the Board, the permit shield, as it applies to the source's existing permit, shall remain in effect until such time as the Board has rendered its final decision.
4. Nothing in this permit alters or affects the ability of the Department to take enforcement action for a violation of an applicable requirement or permit term demonstrated pursuant to ARM 17.8.106, Source Testing Protocol.
 5. Pursuant to ARM 17.8.132, for the purpose of submitting a compliance certification, nothing in these rules shall preclude the use, including the exclusive use, of any credible evidence or information relevant to whether a source would have been in compliance. However, when compliance or noncompliance is demonstrated by a test or procedure provided by permit or other applicable requirements, the source shall then be presumed to be in compliance or noncompliance unless that presumption is overcome by other relevant credible evidence.
 6. The permit shield will not extend to minor permit modifications or changes not requiring a permit revision (see Sections I & J).
 7. The permit shield will extend to significant permit modifications and transfer or assignment of ownership (see Sections K & N).

D. Monitoring, Recordkeeping, and Reporting Requirements

ARM 17.8, Subchapter 12, operating Permit Program §1212(2)&(3)

1. Unless otherwise provided in this permit, the permittee shall maintain compliance monitoring records that include the following information.
 - a. The date, place as defined in the permit, and time of sampling or measurement;
 - b. The date(s) analyses were performed;
 - c. The company or entity that performed the analyses;
 - d. The analytical techniques or methods used;
 - e. The results of such analyses; and
 - f. The operating conditions at the time of sampling or measurement.

2. The permittee shall retain records of all required monitoring data and support information for a period of at least 5 years from the date of the monitoring sample, measurement, report, or application. Support information includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by the permit. All monitoring data, support information, and required reports and summaries may be maintained in computerized form at the plant site if the information is made available to Department personnel upon request, which may be for either hard copies or computerized format. Strip-charts must be maintained in their original form at the plant site and shall be made available to Department personnel upon request.
3. The permittee shall submit to the Department, at the addresses located in the Notification Addresses Appendix of this permit, reports of any required monitoring by January 31 and July 31 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. The monitoring report submitted on January 31 of each year must include the required monitoring information for the period of July 1 through December 31 of the previous year. The monitoring report submitted on July 31 of each year must include the required monitoring information for the period of January 1 through June 30 of the current year. All instances of deviations from the permit requirements must be clearly identified in such reports. All required reports must be certified by a responsible official, consistent with ARM 17.8.1207.

E. Prompt Deviation Reporting

ARM 17.8, Subchapter 12, Operating Permit Program §1212(3)(c)

The permittee shall promptly report deviations from permit requirements, including those attributable to upset conditions as defined in the permit, the probable cause of such deviations, and any corrective actions or preventive measures taken. To be considered prompt, deviations shall be reported as part of the routine reporting requirements under ARM 17.8.1212(3)(b) and, if applicable, in accordance with the malfunction reporting requirements under ARM 17.8.110, unless otherwise specified in an applicable requirement.

F. Emergency Provisions

ARM 17.8, Subchapter 12, Operating Permit Program §1201(13) and §1214(5), (6)&(8)

1. An “emergency” means any situation arising from sudden and reasonably unforeseeable events beyond the control of the source, including acts of God, which situation requires immediate corrective action to restore normal operation and causes the source to exceed a technology-based emission limitation under this permit due to the unavoidable increases in emissions attributable to the emergency. An emergency shall not include noncompliance to the extent caused by improperly designed equipment, lack of reasonable preventive maintenance, careless or improper operation, or operator error.
2. An emergency constitutes an affirmative defense to an action brought for noncompliance with a technology-based emission limitation if the permittee demonstrates through properly signed, contemporaneous logs, or other relevant evidence, that:
 - a. An emergency occurred and the permittee can identify the cause(s) of the emergency.

- b. The permitted facility was at the time being properly operated.
 - c. During the period of the emergency the permittee took all reasonable steps to minimize levels of emissions that exceeded the emission standards or other requirements in the permit.
 - d. The permittee submitted notice of the emergency to the Department within 2 working days of the time when emission limitations were exceeded due to the emergency. This notice fulfills the requirements of ARM 17.8.1212(3)(c). This notice must contain a description of the emergency, any steps taken to mitigate emissions, and corrective actions taken.
3. These emergency provisions are in addition to any emergency, malfunction or upset provision contained in any applicable requirement.

G. Inspection and Entry

ARM 17.8, Subchapter 12, Operating Permit Program §1213(3)&(4)

- 1. Upon presentation of credentials and other requirements as may be required by law, the permittee shall allow the Department, the administrator, or an authorized representative (including an authorized contractor acting as a representative of the Department or the administrator) to perform the following:
 - a. Enter the premises where a source required to obtain a permit is located or emissions-related activity is conducted, or where records must be kept under the conditions of the permit.
 - b. Have access to and copy, at reasonable times, any records that must be kept under the conditions of the permit.
 - c. Inspect at reasonable times any facilities, emission units, equipment (including monitoring and air pollution control equipment), practices, or operations regulated or required under the permit.
 - d. As authorized by the Montana Clean Air Act and rules promulgated thereunder, sample or monitor, at reasonable times, any substances or parameters at any location for the purpose of assuring compliance with the permit or applicable requirements.
- 2. The permittee shall inform the inspector of all workplace safety rules or requirements at the time of inspection. This section shall not limit in any manner the Department's statutory right of entry and inspection as provided for in 75-2-403, MCA.

H. Fee Payment

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(f) and ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation, and Open Burning Fees §505(3)-(5) (STATE ONLY)

- 1. The permittee must pay application and operating fees, pursuant to ARM Title 17, Chapter 8, Subchapter 5.

2. Annually, the Department shall provide the permittee with written notice of the amount of the fee and the basis for the fee assessment. The air quality operation fee is due 30 days after receipt of the notice, unless the fee assessment is appealed pursuant to ARM 17.8.511. If any portion of the fee is not appealed, that portion of the fee that is not appealed is due 30 days after receipt of the notice. Any remaining fee, which may be due after the completion of an appeal, is due immediately upon issuance of the Board's decision or upon completion of any judicial review of the Board's decision.
3. If the permittee fails to pay the required fee (or any required portion of an appealed fee) within 90 days of the due date of the fee, the Department may impose an additional assessment of 15% of the fee (or any required portion of an appealed fee) or \$100, whichever is greater, plus interest on the fee (or any required portion of an appealed fee), computed at the interest rate established under 15-31-510(3), MCA.

I. Minor Permit Modifications

ARM 17.8, Subchapter 12, Operating Permit Program §1226(3)&(11)

1. An application for a minor permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation, or deletion, and may reference any required information that has been previously submitted.
2. The permit shield under ARM 17.8.1214 will not extend to any minor modifications processed pursuant to ARM 17.8.1226.

J. Changes Not Requiring Permit Revision

ARM 17.8, Subchapter 12, Operating Permit Program §1224(1)-(3), (5)&(6)

1. The permittee is authorized to make changes within the facility as described below, provided the following conditions are met.
 - a. The proposed changes do not require the permittee to obtain an air quality preconstruction permit under ARM Title 17, Chapter 8, Subchapter 7.
 - b. The proposed changes are not modifications under Title I of the FCAA, or as defined in ARM Title 17, Chapter 8, Subchapters 8, 9, or 10.
 - c. The emissions resulting from the proposed changes do not exceed the emissions allowable under this permit, whether expressed as a rate of emissions or in total emissions.
 - d. The proposed changes do not alter permit terms that are necessary to enforce applicable emission limitations on emission units covered by the permit.
 - e. The facility provides the administrator and the Department with written notification at least 7 days prior to making the proposed changes.
2. The permittee and the Department shall attach each notice provided pursuant to 1.e above to their respective copies of this permit.

3. Pursuant to the conditions above, the permittee is authorized to make Section 502(b)(10) changes, as defined in ARM 17.8.1201(30), without a permit revision. For each such change, the written notification required under 1.e above shall include a description of the change within the source, the date on which the change will occur, any change in emissions, and any permit term or condition that is no longer applicable as a result of the change.
4. The permittee may make a change not specifically addressed or prohibited by the permit terms and conditions without requiring a permit revision, provided the following conditions are met.
 - a. Each proposed change does not weaken the enforceability of any existing permit conditions.
 - b. The Department has not objected to such change.
 - c. Each proposed change meets all applicable requirements and does not violate any existing permit term or condition.
 - d. The permittee provides contemporaneous written notice to the Department and the administrator of each change that is above the level for insignificant emission units as defined in ARM 17.8.1201(22) and 17.8.1206(3), and the written notice describes each such change, including the date of the change, any change in emissions, pollutants emitted, and any applicable requirement that would apply as a result of the change.
5. The permit shield authorized by ARM 17.8.1214 shall not apply to changes made pursuant to ARM 17.8.1224(3) and (5), but is applicable to terms and conditions that allow for increases and decreases in emissions pursuant to ARM 17.8.1224(4).

K. Significant Permit Modifications

ARM 17.8, Subchapter 12, Operating Permit Program §1227(1), (3)&(4)

1. The modification procedures set forth in 2 below must be used for any application requesting a significant modification of this permit. Significant modifications include the following:
 - a. Any permit modification that does not qualify as either a minor modification or as an administrative permit amendment;
 - b. Every significant change in existing permit monitoring terms or conditions;
 - c. Every relaxation of permit reporting or recordkeeping terms or conditions that limit the Department's ability to determine compliance with any applicable rule, consistent with the requirements of the rule; or
 - d. Any other change determined by the Department to be significant.

2. Significant modifications shall meet all requirements of ARM Title 17, Chapter 8, including those for applications, public participation, and review by affected states and the administrator, as they apply to permit issuance and renewal, except that an application for a significant permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation or deletion.
3. The permit shield provided for in ARM 17.8.1214 shall extend to significant modifications.

L. Reopening For Cause

ARM 17.8, Subchapter 12, Operating Permit Program §1228(1)&(2)

1. This permit may be reopened and revised under the following circumstances.
 - a. Additional applicable requirements under the FCAA become applicable to the facility when the permit has a remaining term of 3 or more years. Reopening and revision of the permit shall be completed not later than 18 months after promulgation of the applicable requirement. No reopening is required under ARM 17.8.1228(1)(a) if the effective date of the applicable requirement is later than the date on which the permit is due to expire, unless the original permit or any of its terms or conditions have been extended pursuant to ARM 17.8.1220(12) or 17.8.1221(2).
 - b. Additional requirements (including excess emission requirements) become applicable to an affected source under the Acid Rain Program. Upon approval by the administrator, excess emission offset plans shall be deemed incorporated into the permit.
 - c. The Department or the administrator determines that the permit contains a material mistake or that inaccurate statements were made in establishing the emission standards or other terms or conditions of the permit.
 - d. The administrator or the Department determines that the permit must be revised or revoked and reissued to ensure compliance with the applicable requirements.

M. Permit Expiration and Renewal

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(g), §1220(11)&(12), and §1205(2)(d)

1. This permit is issued for a fixed term of 5 years.
2. Renewal of this permit is subject to the same procedural requirements that apply to permit issuance, including those for application, content, public participation, and affected state and administrator review.
3. Expiration of this permit terminates the permittee's right to operate unless a timely and administratively complete renewal application has been submitted consistent with ARM 17.8.1221 and 17.8.1205(2)(d). If a timely and administratively complete application has been submitted, all terms and conditions of the permit, including the application shield, remain in effect after the permit expires until the permit renewal has been issued or denied.

4. For renewal, the permittee shall submit a complete air quality operating permit application to the Department not later than 6 months prior to the expiration of this permit, unless otherwise specified. If necessary to ensure that the terms of the existing permit will not lapse before renewal, the Department may specify, in writing to the permittee, a longer time period for submission of the renewal application. Such written notification must be provided at least 1 year before the renewal application due date established in the existing permit.

N. Severability Clause

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(i)&(l)

1. The administrative appeal or subsequent judicial review of the issuance by the Department of an initial permit under this subchapter shall not impair in any manner the underlying applicability of all applicable requirements, and such requirements continue to apply as if a final permit decision had not been reached by the Department.
2. If any provision of a permit is found to be invalid, all valid parts that are severable from the invalid part remain in effect. If a provision of a permit is invalid in one or more of its applications, the provision remains in effect in all valid applications that are severable from the invalid applications.

O. Transfer or Assignment of Ownership

ARM 17.8, Subchapter 12, Operating Permit Program §1225(2)&(4)

1. If an administrative permit amendment involves a change in ownership or operational control, the applicant must include in its request to the Department a written agreement containing a specific date for the transfer of permit responsibility, coverage and liability between the current and new permittee.
2. The permit shield provided for in ARM17.8.1214 shall not extend to administrative permit amendments.

P. Emissions Trading, Marketable Permits, Economic Incentives

ARM 17.8, Subchapter 12, Operating Permit Program §1226(2)

Notwithstanding ARM 17.8.1226(1) and (7), minor air quality operating permit modification procedures may be used for permit modifications involving the use of economic incentives, marketable permits, emissions trading, and other similar approaches, to the extent that such minor permit modification procedures are explicitly provided for in the Montana State Implementation Plan or in applicable requirements promulgated by the administrator.

Q. No Property Rights Conveyed

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(d)

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

R. Testing Requirements

ARM 17.8, Subchapter 1, General Provisions §105

The permittee shall comply with ARM 17.8.105.

S. Source Testing Protocol

ARM 17.8, Subchapter 1, General Provisions §106

The permittee shall comply with ARM 17.8.106.

T. Malfunctions

ARM 17.8, Subchapter 1, General Provisions §110

The permittee shall comply with ARM 17.8.110.

U. Circumvention

ARM 17.8, Subchapter 1, General Provisions §111

The permittee shall comply with ARM 17.8.111.

V. Motor Vehicles

ARM 17.8, Subchapter 3, Emission Standards §325

The permittee shall comply with ARM 17.8.325.

W. Annual Emissions Inventory

ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation and Open Burning Fees §505 (STATE ONLY)

The permittee shall supply the Department with annual production and other information for all emission units necessary to calculate actual or estimated actual amount of air pollutants emitted during each calendar year. Information shall be gathered on a calendar-year basis and submitted to the Department by the date required in the emission inventory request, unless otherwise specified in this permit. Information shall be in the units required by the Department.

X. Open Burning

ARM 17.8, Subchapter 6, Open Burning §604, 605 and 606

The permittee shall comply with ARM 17.8.604, 605 and 606.

Y. Preconstruction Permits

ARM 17.8, Subchapter 7, Permit, Construction and Operation of Air Contaminant Sources §705, 708 and 733 (ARM 17.8.705(1)(r), 708 and 733(1)(b) are STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP)

1. Except as specified, no person shall construct, install, alter or use any air contaminant source or stack associated with any source without first obtaining a permit from the Department or Board. A permit is not required for those sources or stacks as specified by ARM 17.8.705(1)(a)-(q).
2. The permittee shall comply with ARM 17.8.705, 706 and 733.

3. ARM 17.8.705(1)(r)(i) specifies de minimis changes as construction or changed conditions of operation at a facility holding an air quality preconstruction permit issued under Chapter 8 that does not increase the facility's potential to emit by more than 15 tons per year of any pollutant, except (STATE ENFORCEABLE ONLY until approved by the EPA as part of the SIP):
 - a. Any construction or changed condition that would violate any condition in the facility's existing air quality preconstruction permit or any applicable rule contained in Chapter 8 is prohibited, except as provided in ARM 17.8.705(2).
 - b. Any construction or changed conditions of operation that would qualify as a major modification under Subchapters 8, 9 or 10 of Chapter 8.
 - c. Any construction or changed condition of operation that would affect the plume rise or dispersion characteristic of emissions that would cause or contribute to a violation of an ambient air quality standard or ambient air increment as defined in ARM 17.8.804.
 - d. Any construction or improvement project with a potential to emit more than 15 tons per year may not be artificially split into smaller projects to avoid air quality preconstruction permitting.
 - e. Emission reductions obtained through offsetting within a facility are not included when determining the potential emission increase from construction or changed conditions of operation, unless such reductions are made federally enforceable.
4. Any facility making a de minimis change pursuant to ARM 17.8.705(1)(r) shall notify the Department if the change would include a change in control equipment, stack height, stack diameter, 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, 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 17.8.705(1)(r)(iv). (STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP)

Z. National Emission Standard for Asbestos

40 CFR, Part 61, Subpart M

The permittee shall not conduct any asbestos abatement activities except in accordance with 40 CFR 61, Subpart M (National Emission Standard for Hazardous Air Pollutants for Asbestos).

AA. Asbestos

ARM 17.74, Subchapter 3, General Provisions and Subchapter 4, Fees

The permittee shall comply with ARM 17.74.301, et seq., and ARM 17.74.401, et seq. (State only)

BB. Stratospheric Ozone Protection – Servicing of Motor Vehicle Air Conditioners

40 CFR, Part 82, Subpart B

If the permittee performs a service on motor vehicles and this service involves ozone-depleting substance/refrigerant in the motor vehicle air conditioner (MVAC), the permittee is subject to all the applicable requirements as specified in 40 CFR 82, Subpart B.

CC. Stratospheric Ozone Protection – Recycling and Emission Reductions

40 CFR, Part 82, Subpart F

The permittee shall comply with the standards for recycling and emission reductions in 40 CFR 82, Subpart F, except as provided for MVACs in Subpart B.

1. Persons opening appliances for maintenance, service, repair, or disposal must comply with the required practices pursuant to §82.156.
2. Equipment used during the maintenance, service, repair or disposal of appliances must comply with the standards for recycling and recovery equipment pursuant to §82.158.
3. Persons performing maintenance, service, repair or disposal of appliances must be certified by an approved technical certification program pursuant to §82.161.
4. Persons disposing of small appliances, MVACs and MVAC-like (as defined at §82.152) appliances must comply with recordkeeping requirements pursuant to §82.166.
5. Persons owning commercial or industrial process refrigeration equipment must comply with the leak repair requirements pursuant to §82.156.
6. Owners/operators of appliances normally containing 50 or more pounds of refrigerant must keep records of refrigerant purchased and added to such appliances pursuant to §82.166.

DD. Emergency Episode Plan

The permittee shall comply with the requirements contained in Chapter 9.7 of the State of Montana Air Quality Control Implementation Plan.

Each major source emitting 100 tons per year located in a Priority I Air Quality Control Region, shall submit to the Department a legally enforceable Emergency Episode Action Plan (EEAP) that details how the source will curtail emissions during an air pollutant emergency episode. The industrial EEAP shall be in accordance with the Department's EEAP and shall be submitted according to a timetable developed by the Department, following Priority I reclassification.

EE. Definitions

Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit, shall have the meaning assigned to them in the referenced regulations.

APPENDICES

App. A RULE CITATION

Pursuant to Chapter 418, Laws of Montana 1995, effective July 1, 1995, the Air Quality Division was transferred from the Department of Health and Environmental Sciences to the Department of Environmental Quality. To implement the legislation, ARM 16.8.101 through ARM 16.8.2025, and 16.9.101 through 16.9.106, except any repealed rules, were transferred to the Department of Environmental Quality as ARM 17.8.101 through 17.8.1234 and 17.80.101 through 17.80.106 effective August 22, 1996. On September 19, 1997, the rule transfer was submitted to EPA and is pending approval as part of the State Implementation Plan (SIP). The old citations are still cited in the SIP until EPA approves the rule transfer.

NEW CITATION

OLD CITATION

Sub-chapter 1 – General Provisions

17.8.101	Definitions	16.8.701
17.8.102	Incorporation by Reference - Publication Dates and Availability of Referenced Documents	16.8.710
17.8.103	Incorporation by Reference	16.8.708
17.8.105	Testing Requirements	16.8.704
17.8.106	Source Testing Protocol	16.8.709
17.8.110	Malfunctions	16.8.705
17.8.111	Circumvention	16.8.707
17.8.120	Variance Procedures – Initial Application	16.8.101
17.8.121	Variance Procedures – Renewal Application	16.8.102
17.8.130	Enforcement Procedures – Notice of Violation –Order to Take Corrective Action	16.8.201
17.8.131	Enforcement Procedures – Appeal to Board	16.8.202
17.8.140	Rehearing Procedures – Form and Filing of Petition	16.8.302
17.8.141	Rehearing Procedures – Filing Requirements	16.8.303
17.8.142	Rehearing Procedures – Board Review	16.8.304

Sub-chapter 2 – Ambient Air Quality

17.8.201	Definitions	16.8.806
17.8.202	Incorporation by Reference	16.8.823
17.8.204	Ambient Air Monitoring	16.8.807
17.8.205	Enforceability	16.8.808
17.8.206	Methods and Data	16.8.809
17.8.210	Ambient Air Quality Standards for Sulfur Dioxide	16.8.820
17.8.211	Ambient Air Quality Standards for Nitrogen Dioxide	16.8.816
17.8.212	Ambient Air Quality Standards for Carbon Monoxide	16.8.811
17.8.213	Ambient Air Quality Standards for Ozone	16.8.817
17.8.214	Ambient Air Quality Standards for Hydrogen Sulfide	16.8.814
17.8.220	Ambient Air Quality Standards for Settled Particulate Matter	16.8.818
17.8.221	Ambient Air Quality Standards for Visibility	16.8.822
17.8.222	Ambient Air Quality Standards for Lead	16.8.815
17.8.223	Ambient Air Quality Standards for PM-10	16.8.821
17.8.230	Fluoride in Forage	16.8.813

Sub-chapter 3 – Emission Standards		
17.8.301	Definitions	16.8.1430
17.8.302	Incorporation by Reference	16.8.1429
17.8.304	Visible Air Contaminants	16.8.1404
17.8.308	Particulate Matter, Airborne	16.8.1401
17.8.309	Particulate Matter, Fuel Burning Equipment	16.8.1402
17.8.310	Particulate Matter, Industrial Processes	16.8.1403
17.8.315	Odors	16.8.1427
17.8.316	Incinerators	16.8.1406
17.8.320	Wood-Waste Burners	16.8.1407
17.8.321	Kraft Pulp Mills	16.8.1413
17.8.322	Sulfur Oxide Emissions – Sulfur in Fuel	16.8.1411
17.8.323	Sulfur Oxide Emissions – Primary Copper Smelters	16.8.1412
17.8.324	Hydrocarbon Emissions – Petroleum Products	16.8.1425
17.8.325	Motor Vehicles	16.8.1426
17.8.326	Prohibited Materials for Wood or Coal Residential Stoves	16.8.1428
17.8.330	Emission Standards for Existing Aluminum Plants- Definitions	16.8.1501
17.8.331	Emission Standards for Existing Aluminum Plants- Standards for Fluoride	16.8.1502
17.8.332	Emission Standards for Existing Aluminum Plants- Standard	16.8.1503
17.8.333	Emission Standards for Existing Aluminum Plants - Monitoring and Reporting	16.8.1504
17.8.334	Emission Standards for Existing Aluminum Plants - Startup and Shutdown	16.8.1505
17.8.340	Standard of Performance for New Stationary Sources	16.8.1423
17.8.341	Emission Standards for Hazardous Air Pollutants	16.8.1424
17.8.342	Emission Standards for Hazardous Air Pollutants for Source Categories	16.8.1431
Sub-chapter 4 – Stack Heights and Dispersion Techniques		
17.8.401	Definitions	16.8.1204
17.8.402	Requirements	16.8.1205
17.8.403	Exemptions	16.8.1206
Sub-chapter 5 – Air Quality Permit Application, Operation, and Open Burning Fees		
17.8.501	Definitions	16.8.1901
17.8.504	Air Quality Permit Application Fees	16.8.1905
17.8.505	Air Quality Operation Fees	16.8.1903
17.8.510	Annual Review	16.8.1902
17.8.511	Air Quality Permit Application/Operation Fee	16.8.1906
17.8.514	Air Quality Open Burning Fees	16.8.1907
17.8.515	Air Quality Open Burning Fees for Conditional, Emergency, Christmas Tree Waste, and Commercial Film Production Open Burning Permits	16.8.1908
Sub-chapter 6 – Open Burning		
17.8.601	Definitions	16.8.1301
17.8.602	Incorporation by Reference	16.8.1311
17.8.604	Prohibited Open Burning – When Permit Required	16.8.1302
17.8.605	Special Burning Periods	16.8.1305

17.8.606	Minor Open Burning Source Requirements	16.8.1303
17.8.610	Major Open Burning Source Restrictions	16.8.1304
17.8.611	Emergency Open Burning Permits	16.8.1308
17.8.612	Conditional Air Quality Open Burning Permits	16.8.1307
17.8.613	Christmas Tree Waste Open Burning Permits	16.8.1309
17.8.614	Commercial Film Production Open Burning Permits	16.8.1310
17.8.615	Firefighter Training	16.8.1306

Sub-chapter 7 – Permit, Construction and Operation of Air Contaminant Sources

17.8.701	Definitions	16.8.1101
17.8.702	Incorporation by Reference	16.8.1120
17.8.704	General Procedures for Air Quality Preconstruction Permitting	16.8.1119
17.8.705	When Permit Required – Exclusions	16.8.1102
17.8.706	New or Altered Sources and Stacks – Permit Application Requirements	16.8.1105
17.8.707	Waivers	16.8.1118
17.8.708	Notification of Emissions Increase	16.8.1121
17.8.710	Conditions for Issuance of Permit	16.8.1109
17.8.715	Emission Control Requirements	16.8.1103
17.8.716	Inspection of Permit	16.8.1115
17.8.717	Compliance with Other Statutes and Rules	16.8.1117
17.8.720	Public Review of Permit Application	16.8.1107
17.8.730	Denial of Permit	16.8.1110
17.8.731	Duration of Permit	16.8.1111
17.8.732	Revocation of Permit	16.8.1112
17.8.733	Modification of Permit	16.8.1113
17.8.734	Transfer of Permit	16.8.1114

Sub-chapter 8 – Prevention of Significant Deterioration of Air Quality

17.8.801	Definitions	16.8.945
17.8.802	Incorporation by Reference	16.8.946
17.8.804	Ambient Air Increments	16.8.947
17.8.805	Ambient Air Ceilings	16.8.948
17.8.806	Restrictions on Area Classifications	16.8.949
17.8.807	Exclusions from Increment Consumption	16.8.950
17.8.808	Redesignation	16.8.951
17.8.809	Stack Heights	16.8.952
17.8.818	Review of Major Stationary Sources and Major Modification – Source Applicability and Exemptions	16.8.953
17.8.819	Control Technology Review	16.8.954
17.8.820	Source Impact Analysis	16.8.955
17.8.821	Air Quality Models	16.8.956
17.8.822	Air Quality Analysis	16.8.957
17.8.823	Source Information	16.8.958
17.8.824	Additional Impact Analyses	16.8.959
17.8.825	Sources Impacting Federal Class I Areas – Additional	16.8.960
17.8.826	Public Participation	16.8.961
17.8.827	Source Obligation	16.8.962
17.8.828	Innovative Control Technology	16.8.963

Sub-chapter 9 – Permit Requirements for Major Stationary Sources or Major Modifications

Located within Nonattainment Areas

17.8.901	Definitions	16.8.1701
17.8.902	Incorporation by Reference	16.8.1702
17.8.904	When Air Quality Preconstruction Permit Required	16.8.1703
17.8.905	Additional Conditions of Air Quality Preconstruction Permit	16.8.1704
17.8.906	Baseline for Determining Credit for Emissions and Air Quality Offsets	16.8.1705

Sub-chapter 10 – Preconstruction Permit Requirements for Major Stationary Sources or Major Modifications Located within Attainment or Unclassified Areas

17.8.1001	Definitions	16.8.1801
17.8.1002	Incorporation by Reference	16.8.1802
17.8.1004	When Air Quality Preconstruction Permit Required	16.8.1803
17.8.1005	Additional Conditions of Air Quality Preconstruction Permit	16.8.1804
17.8.1006	Review of Specified Sources for Air Quality Impact	16.8.1805
17.8.1007	Baseline for Determining Credit for Emissions and Air Quality Offsets	16.8.1806

Sub-chapter 11 – Visibility Impact Assessment

17.8.1101	Definitions	16.8.1002
17.8.1102	Incorporation by Reference	16.8.1009
17.8.1103	Applicability – Visibility Requirements	16.8.1001
17.8.1106	Visibility Impact Analysis	16.8.1003
17.8.1107	Visibility Models	16.8.1004
17.8.1108	Notification of Permit Application	16.8.1005
17.8.1109	Adverse Impact of Federal Land Manager	16.8.1006
17.8.1110	Visibility Monitoring	16.8.1007
17.8.1111	Additional Impact Analysis	16.8.1008

Sub-chapter 12 – Operating Permit Program

17.8.1201	Definitions	16.8.2002
17.8.1202	Incorporation by Reference	16.8.2003
17.8.1203	Air Quality Operating Permit Program Overview	16.8.2001
17.8.1204	Air Quality Operating Permit Program Applicability	16.8.2004
17.8.1205	Requirements for Timely and Complete Air Quality Permit Applications	16.8.2005
17.8.1206	Information Required for Air Quality Operating Permit Applications	16.8.2006
17.8.1207	Certification of Truth, Accuracy, and Completeness	16.8.2007
17.8.1210	General Requirements for Air Quality Operating Permit Content	16.8.2008
17.8.1211	Requirements for Air Quality Operating Permit Content Relating to Emission Limitations and Standards, and Other Requirements	16.8.2009
17.8.1212	Requirements for Air Quality Operating Permit Content Relating to Monitoring, Recordkeeping and Reporting	16.8.2010
17.8.1213	Requirements for Air Quality Operating Permit Content Relating to Compliance	16.8.2011
17.8.1214	Requirements for Air Quality Operating Permit Content Relating to the Permit Shield and Emergencies	16.8.2012

17.8.1215	Requirements for Air Quality Operating Permit Content Relating to Operational Flexibility	16.8.2013
17.8.1220	Air Quality Operating Permit Issuance, Renewal, Reopening and Modification	16.8.2014
17.8.1221	Operation Without an Air Quality Operating Permit and Application Shield	16.8.2015
17.8.1222	General Air Quality Operating Permits	16.8.2016
17.8.1223	Temporary Air Quality Operating Permits	16.8.2017
17.8.1224	Additional Requirements for Operational Flexibility and Air Quality Operating Permit Changes that do not Require Revisions	16.8.2018
17.8.1225	Additional Requirements for Air Quality Operating Permit Amendments	16.8.2019
17.8.1226	Additional Requirements for Minor Air Quality Operating Permit Modifications	16.8.2020
17.8.1227	Additional Requirements for Significant Air Quality Operating Permit Modifications	16.8.2021
17.8.1228	Additional Requirements for Air Quality Operating Permit Revocation, Reopening and Revision for Cause	16.8.2022
17.8.1231	Notice of Termination, Modification, or Revocation and Reissuance by the Administrator for Cause	16.8.2023
17.8.1232	Public Participation	16.8.2024
17.8.1233	Permit Review by the Administrator and Affected States	16.8.2025
17.8.1234	Acid Rain – Permit Regulation	16.8.2026

Chapter 80 – Air and Water Quality – Tax Certification

	Sub-chapter 1 – Tax Certification for Pollution Control Equipment	
17.80.101	Definitions	16.9.101
17.80.102	Application for Certification as Air or Water Pollution Equipment	16.9.102
17.80.103	Eligibility Criteria	16.9.103
17.80.104	Apportionment Procedures	16.9.104
17.80.105	Compliance	16.9.105
17.80.106	Informal Conference	16.9.106

App. B INSIGNIFICANT EMISSION UNITS

Disclaimer: The information in this appendix is not State or Federally enforceable, but is presented to assist Cenex, the permitting authority, inspectors, and the public.

Pursuant to ARM 17.8.1201(22)(a), an insignificant emission unit means any activity or emission unit located within a source that: (i) has a potential to emit less than 5 tons per year of any regulated pollutant; (ii) has a potential to emit less than 500 pounds per year of lead; (iii) has a potential to emit less than 500 pounds per year of hazardous air pollutants listed pursuant to section 7412 (b) of the FCAA; and (iv) is not regulated by an applicable requirement, other than a generally applicable requirement that applies to all emission units subject to Subchapter 12.

List of Insignificant Activities:

The following table of insignificant sources and/or activities were provided by Cenex. Because there are no requirements to update such a list, the emission units and/or activities may change from those specified in the table.

Emission Unit ID	Description
IEU01	Electric heater and motors
IEU02	Cooling water service and return
IEU03	Service and storage with < 10% hydrocarbons
IEU04	Steam system
IEU05	Plant air system including but not limited to instrument air piping and air compressors
IEU06	Fresh water system, including but not limited to the river pumping system and boiler feedwater treatment system
IEU07	Crude pipelines supplying the refinery and product pipelines from the refinery
IEU08	Natural gas fired space heaters in buildings
IEU09	Tanks under pressure
IEU10	Any functions performed in shop areas, including but not limited to the machine shop and paint shop
IEU11	Any chemicals contained in spray paint, lubricants, etc.
IEU12	Any nuclear density gauges and measurement devices
IEU13	Any diesel-driven equipment such as pumps
IEU14	Laboratory activities
IEU15	Air preheater during FCC startups

App. C DEFINITIONS and ABBREVIATIONS

"Act" means the Clean Air Act, as amended, 42 U.S. 7401, et seq.

"Administrative permit amendment" means an air quality operating permit revision that:

- (a) Corrects typographical errors;
- (b) Identifies a change in the name, address or phone number of any person identified in the air quality operating permit, or identifies a similar minor administrative change at the source;
- (c) Requires more frequent monitoring or reporting by Cenex;
- (d) Requires changes in monitoring or reporting requirements that the Department deems to be no less stringent than current monitoring or reporting requirements;
- (e) Allows for a change in ownership or operational control of a source if the Department has determined that no other change in the air quality operating permit is necessary, consistent with ARM 17.8.1225; or
- (f) Incorporates any other type of change which the Department has determined to be similar to those revisions set forth in (a)-(e), above.

"Applicable requirement" means all of the following as they apply to emissions units in a source requiring an air quality operating permit (including requirements that have been promulgated or approved by the Department or the administrator through rule making at the time of issuance of the air quality operating permit, but have future-effective compliance dates, provided that such requirements apply to sources covered under the operating permit):

- (a) Any standard, rule, or other requirement, including any requirement contained in a consent decree or judicial or administrative order entered into or issued by the Department, that is contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;
- (b) Any federally enforceable term, condition or other requirement of any air quality preconstruction permit issued by the Department under subchapters 7, 8, 9 and 10 of this chapter, or pursuant to regulations approved or promulgated through rule making under Title I of the FCAA, including parts C and D;
- (c) Any standard or other requirement under sec. 7411 of the FCAA, including sec. 7411(d);
- (d) Any standard or other requirement under sec. 7412 of the FCAA, including any requirement concerning accident prevention under sec. 7412(r)(7), but excluding the contents of any risk management plan required under sec. 7412(r);
- (e) Any standard or other requirement of the acid rain program under Title IV of the FCAA or regulations promulgated thereunder;
- (f) Any requirements established pursuant to sec. 7661c(b) or sec. 7414(a)(3) of the FCAA;
- (g) Any standard or other requirement governing solid waste incineration, under sec. 7429 of the FCAA;
- (h) Any standard or other requirement for consumer and commercial products, under sec. 7511b(e) of the FCAA;
- (i) Any standard or other requirement for tank vessels, under sec. 7511b(f) of the FCAA;
- (j) Any standard or other requirement of the regulations promulgated to protect stratospheric ozone under Title VI of the FCAA, unless the administrator determines that such requirements need not be contained in an air quality operating permit;

- (k) Any national ambient air quality standard or increment or visibility requirement under part C of Title I of the FCAA, but only as it would apply to temporary sources permitted pursuant to sec. 7661c(e) of the FCAA; or
- (l) Any federally enforceable term or condition of any air quality open burning permit issued by the Department under subchapter 6.

"Department" means the Montana Department of Environmental Quality.

"Emission unit" means any part or activity of a stationary source that emits or has the potential to emit any regulated air pollutant or any pollutant listed under sec. 7412(b) of the FCAA. This term is not meant to alter or affect the definition of the term "unit" for purposes of Title IV of the FCAA.

"FCAA" means the Federal Clean Air Act, as amended.

"Federally enforceable" means all limitations and conditions which are enforceable by the administrator, including those requirements developed pursuant to 40 CFR Parts 60 and 61, requirements within the Montana state implementation plan, and any permit requirement established pursuant to 40 CFR 52.21 or under regulations approved pursuant to 40 CFR Part 51, Subpart I, including operating permits issued under an EPA approved program that is incorporated into the Montana state implementation plan and expressly requires adherence to any permit issued under such program.

"Fugitive emissions" means those emissions that could not reasonably pass through a stack, chimney, vent, or other functionally equivalent opening.

"General air quality operating permit" or **"general permit"** means an air quality operating permit that meets the requirements of ARM 17.8.1222, covers multiple sources in a source category, and is issued in lieu of individual permits being issued to each source.

"Hazardous air pollutant" means any air pollutant listed as a hazardous air pollutant pursuant to section 112(b) of the FCAA.

"Non-federally enforceable requirement" means the following as they apply to emissions units in a source requiring an air quality operating permit:

- (a) Any standard, rule, or other requirement, including any requirement contained in a consent decree, or judicial or administrative order entered into or issued by the Department, that is not contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;
- (b) Any term, condition or other requirement contained in any air quality preconstruction permit issued by the Department under subchapters 7, 8, 9 and 10 of this chapter that is not federally enforceable;
- (c) Does not include any Montana ambient air quality standard contained in Subchapter 2 of this chapter.

"Permittee" means the owner or operator of any source subject to the permitting requirements of this subchapter, as provided in ARM 17.8.1204, that holds a valid air quality operating permit or has submitted a timely and complete permit application for issuance, renewal, amendment, or modification pursuant to this subchapter.

"Regulated air pollutant" means the following:

- (a) Nitrogen oxides or any volatile organic compounds;
- (b) Any pollutant for which a national ambient air quality standard has been promulgated;
- (c) Any pollutant that is subject to any standard promulgated under sec. 7411 of the FCAA;
- (d) Any Class I or II substance subject to a standard promulgated under or established by Title VI of the FCAA; or
- (e) Any pollutant subject to a standard or other requirement established or promulgated under sec. 7412 of the FCAA, including but not limited to the following:
 - (i) Any pollutant subject to requirements under sec. 7412(j) of the FCAA. If the administrator fails to promulgate a standard by the date established in section 7412(e) of the FCAA, any pollutant for which a subject source would be major shall be considered to be regulated on the date 18 months after the applicable date established in section 7412(e) of the FCAA;
 - (ii) Any pollutant for which the requirements of section 7412(g)(2) of the FCAA have been met but only with respect to the individual source subject to sec. 7412(g)(2) requirement.

"Responsible official" means one of the following:

- (a) For a corporation: a president, secretary, treasurer, or vice-president of the corporation in charge of a principal business function, or any other person who performs similar policy or decision-making functions for the corporation, or a duly authorized representative of such person if the representative is responsible for the overall operation of one or more manufacturing, production, or operating facilities applying for or subject to a permit and either:
 - (i) The facilities employ more than 250 persons or have gross annual sales or expenditures exceeding \$25 million (in second quarter 1980 dollars); or
 - (ii) The delegation of authority to such representative is approved in advance by the Department.
- (b) For a partnership or sole proprietorship: a general partner or the proprietor, respectively.
- (c) For a municipality, state, federal, or other public agency: either a principal executive officer or ranking elected official. For the purposes of this part, a principal executive officer of a federal agency includes the chief executive officer having responsibility for the overall operations of a principal geographic unit of the agency (e.g., a regional administrator of the environmental protection agency).
- (d) For affected sources: the designated representative in so far as actions, standards, requirements, or prohibitions under Title IV of the FCAA or the regulations promulgated thereunder are concerned, and the designated representative for any other purposes under this subchapter.

Abbreviations:

Alky Alkylation
ARM Administrative Rules of Montana
OP1821-00 C-3

Date of Decision: 10/12/01
Effective Date: 11/11/01

ASTM	American Society of Testing Materials
BACT	Best Available Control Technology
BTU	British Thermal Unit
CEMS	Continuous Emission Monitoring System
CFR	Code of Federal Regulations
CFRM	Continuous Flow Rate Monitor
COMS	Continuous Opacity Monitor System
CO	carbon monoxide
DAS	Data Acquisition System
DEQ	Department of Environmental Quality
dscf	dry standard cubic foot
dscfm	dry standard cubic foot per minute
EEAP	Emergency Episode Action Plan
EPA	U.S. Environmental Protection Agency
EPA Method	Test methods contained in 40 CFR 60, Appendix A
EU	emission unit
FCAA	Federal Clean Air Act
FCC	Fluid Catalytic Cracking
gr	grains
HAP	hazardous air pollutant
HF	Hydrogen fluoride
H ₂ S	Hydrogen sulfide
IEU	insignificant emission unit
MACT	Maximum Achievable Control Technology
Method 5	40 CFR 60, Appendix A, Method 5
Method 9	40 CFR 60, Appendix A, Method 9
MMBTU	million British Thermal Units
NESHAPS	National Emission Standards for Hazardous Air Pollutants
NSPS	New Source Performance Standard
NO _x	oxides of nitrogen
NO ₂	nitrogen dioxide
O ₂	oxygen
Pb	lead
PM	particulate matter
PM10	particulate matter less than 10 microns in size
psi	pounds per square inch
RATA	Relative Accuracy Test Audit
scf	standard cubic feet
SIC	Source Industrial Classification
SO ₂	sulfur dioxide
SO _x	oxides of sulfur
SWSOH	Sour water stripper overheads
tpy	tons per year
U.S.C.	United States Code
VE	visible emissions
VOC	volatile organic compound

App. D NOTIFICATION ADDRESSES

Compliance Notifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air & Waste Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

DEQ - Air and Waste Management Bureau
Airport Industrial Park 1P-9
1371 Rintop Dr
Billings MT 59105-1978

United States EPA
Air Program Coordinator
Region VIII, Montana Office
301 South Park, Drawer 10096
Helena, MT 59626-0096

Permit Modifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air & Waste Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

Office of Partnerships and Regulatory Assistance
Air and Radiation Program
US EPA Region VIII 8P-AR
999 18th Street, Suite 500
Denver, CO 80202-2466

App. E AIR QUALITY INSPECTOR INFORMATION

Disclaimer: The information in this appendix is not State or Federally enforceable but is presented to assist Cenex, permitting authority, inspectors, and the public.

1. **Direction to Plant:** 802 South Highway 212, Laurel, Montana, 59044
2. **Safety Equipment Required:** Cenex has an extensive safety orientation package that inspectors and/or visitors must participate in.

In order to access areas of the refinery (in addition to the Administration Building and the offices on the second floor of the Engineers Building), inspectors/visitors must view a refinery hazard awareness training video and either provide their own, or be issued, any required personal protective equipment (PPE). As a minimum, a hard-hat and safety glasses are required. In addition, they must either be accompanied by the refinery contact person or follow an approved, designated route and only visit approved locations. Visitors are also required to sign in and out and obtain passes based on necessary access.

3. **Facility Plot Plan:** An updated facility plot plan was submitted on September 3, 1999.

**App. F JUNE 12, 1998 BOARD ORDERS ADOPTING A SO₂
CONTROL PLAN**