State of Montana
Department of Environmental Quality
Helena, Montana 59620

AIR QUALITY OPERATING PERMIT NUMBER OP2912-04

Renewal Application Received: **May 18, 2004**
Application Deemed Administratively Complete: **May 18, 2004**
Application Deemed Technically Complete: **May 18, 2004**
AFS Number: **030-111-0007A**

Draft Issue Date: **July 14, 2005**
Proposed Issue Date: **August 31, 2005**
End of EPA 45-day Review: **October 17, 2005**
Date of Decision: **October 19, 2005**
Effective Date: **November 19, 2005**
Expiration Date: **November 19, 2010**

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

The Western Sugar Cooperative
Northeast ¼ of Section 10, Township 1 South, Range 26 East, Yellowstone County
3020 State Avenue
Billings, MT 59107

hereinafter, referred to as "Western Sugar", 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, Western Sugar 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 state only enforceable are identified as such 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 Process: In accordance with 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 the decision issued October 19, 2005. The decision may be appealed to the Board of Environmental Review by filing a request for a hearing within 30 days after the date of decision. If no appeal is filed then the Department will send notification and a final permit cover page to be attached to this document stating that the permit is final. In addition, ARM 17.8.1233 allows for any person to petition the Environmental Protection Agency (EPA) within 60 days after the expiration of EPA's 45-day review period to object to 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, and all affected parties will be informed of the stay of a final permit. If the Department has already notified Western Sugar and all affected parties, the Department shall issue a revised permit according to ARM 17.8.1231. Questions regarding the final issuance date and status of appeals should be directed to the Department at (406) 444-3490.

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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: **The Western Sugar Cooperative**

Mailing Address: **7555 E. Hampden Ave., Suite 600**

City: **Denver** State: **Colorado** Zip: **80231**

Plant Location: **3020 State Avenue, Billings, Montana 59107**

Responsible Official: **Mr. Inder K. Mathur, President and CEO** Phone: **(303) 830-3939**

Alternate Responsible Official: **Mr. Ken Bennett, Factory Manager** Phone: **(406) 247-8010**

Facility Contact Person: **Ken Bennett**

Primary SIC Code: **2063**

Nature of Business: **Sugar Beet Processing/Sugar Production**

Description of Process: Sugar beets are transported or trucked to the plant, screened for dirt and rock, and either fed into the plant or moved to storage. Additional dirt is then removed in a washing process. The beets enter the plant and are sliced into long thin strips, referred to as "cossettes." Cossettes are conveyed into a diffuser where the beet sugar is removed with water and heat. The juice is purified, followed by an evaporation of a portion of the entrainment liquid, and finally crystallized. The remaining liquid (molasses) is removed in a centrifuge. The crystallized sugar is then sized, packaged, and shipped. The molasses is shipped to the Western Sugar Scottsbluff NE facility where additional sugar is extracted. Desugared molasses is then shipped back to Billings and sold as a feed supplement or added to pulp in a drying and palletizing process and sold as animal feed.

SECTION II. SUMMARY OF EMISSION UNITS

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

Emissions Unit ID	Description	Pollution Control Device/Practice
EU001	132 MMBtu/hr Erie City Boiler #1	Natural Gas Fuel Only
EU002	Boiler House Stack, (148 MMBtu/hr Riley Boilers; #2, #3, and #4)	Wet Scrubber, Mist Eliminator, Multicyclones
EU003	17 MMBtu/hr Clever Brooks Boiler #5	Natural Gas Fuel Only
EU004	26.6 MMBtu/hr Pulp Dryers	Wet Scrubber, Mist Eliminator, Multicyclones
EU005	Pellet Mills/ Conveyor	Multicyclones
EU006	Pelletizer-Cooler	Multicyclones
EU007	(2) Air Dryer and (2) Steam Sugar Granulators	(2)Wet Scrubbers/(2)Baghouses
EU008	Lime Slaker Vent	Wet Scrubber
EU009	Burnt Lime Collector	Baghouse
EU010	Truck Hauling-Fugitives	Water Spray
EU017	Warehouse Sugar Dust Collector	Dust Collector is Control Device

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 17.8.105	Testing Requirements	Testing 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 17.8.308(1)	Particulate Matter, Airborne	Fugitive Opacity	20%
A.5	ARM 17.8.308(2)	Particulate Matter, Airborne	Reasonable Precautions	-------
A.6	ARM 17.8.308	Particulate Matter, Airborne	Reasonable Precaution, Construction	20%
A.7	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.8	ARM 17.8.310	Particulate Matter, Industrial Processes	Particulate Matter	$E= 4.10 * P^{0.67}$ or $E= 55 * P^{0.11} - 40$
A.9	ARM 17.8.322(4)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (Liquid or Solid Fuels)	1 lb/MMBtu Fired
A.10	ARM 17.8.322(5)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (gaseous)	50 gr/100 CF
A.11	ARM 17.8.324(3)	Hydrocarbon Emissions, Petroleum Products	Gasoline Storage Tanks	-------
A.12	ARM 17.8.324	Hydrocarbon Emissions, Petroleum Products	65,000 Gallon Capacity	-------
A.13	ARM 17.8.324	Hydrocarbon Emissions, Petroleum Products	Oil-effluent Water Separator	-------
A.14	STIP, Exhibit A, Section 3.C	Campaign Length	Campaign Length	190 Days
A.15	ARM 17.8.342	NESHAPs General Provisions	SSM Plans	Submittal
A.16	ARM 17.8.1212	Reporting Requirements	Compliance Monitoring	-------
A.17	ARM 17.8.1207	Reporting Requirements	Annual Certification	-------

Conditions

A.1. Pursuant to ARM 17.8.105, any person or persons responsible for the emission of any air contaminant into the outdoor atmosphere shall, upon written request of the Department, provide the facilities and necessary equipment (including instruments and sensing devices) and shall conduct tests, emission or ambient, for such periods of time as may be necessary using methods approved by the Department.

Compliance demonstration frequencies that list “as required by the Department” refer to ARM 17.8.105. In addition, for such sources, compliance with limits and conditions listing “as required by the Department” as the frequency, is verified annually using emission factors and engineering calculations by the Department’s compliance inspectors during the annual emission inventory review; in the case of Method 9 tests, compliance is monitored during the annual inspection by the compliance inspector.

A.2. Pursuant to ARM 17.8.304(1), Western Sugar 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 six consecutive minutes, unless otherwise specified by rule or in this permit.

A.3. Pursuant to ARM 17.8.304(2), Western Sugar 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 six consecutive minutes, unless otherwise specified by rule or in this permit.

A.4. Pursuant to ARM 17.8.308(1), Western Sugar 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 an opacity of 20% or greater averaged over six consecutive minutes, unless otherwise specified by rule or in this permit.

A.5. Pursuant to ARM 17.8.308(2), Western Sugar 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.6. Pursuant to ARM 17.8.308, Western Sugar 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 an opacity of 20% or greater averaged over six consecutive minutes, unless otherwise specified by rule or in this permit.

A.7. Pursuant to ARM 17.8.309, unless otherwise specified by rule or in this permit, Western Sugar 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 emissions rate in pounds per MMBtu.

A.8. Pursuant to ARM 17.8.310, unless otherwise specified by rule or in this permit, Western Sugar 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 = rate of emissions in pounds per hour and p = process weight rate in tons per hour.

A.9. Pursuant to ARM 17.8.322(4), Western Sugar shall not burn liquid or solid fuels containing sulfur in excess of 1 pound per MMBtu fired, unless otherwise specified by rule or in this permit. ARM 17.8.322 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 one pound of sulfur per MMBtu fired. This rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per MMBtu 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 (EPA approved State Implementation Plan (SIP), May 2, 2002).

A.10. Pursuant to ARM 17.8.322(5), Western Sugar 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. ARM 17.8.322 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 one pound of sulfur per MMBtu fired. This rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per MMBtu 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 (EPA approved SIP, May 2, 2002).

A.11. Pursuant to ARM 17.8.324(3), Western Sugar 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.12. Pursuant to ARM 17.8.324, unless otherwise specified by rule or in this permit, Western Sugar 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.13. Pursuant to ARM 17.8.324, unless otherwise specified by rule or in this permit, Western Sugar 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 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.14. Pursuant to the Stipulation, (Appendix E of this permit) Western Sugar shall not allow the length of any campaign (normally September through the following February) to exceed 190 days (EPA approved SIP, May 2, 2002).

A.15. Pursuant to ARM 17.8.342 and 40 CFR 63.6, Western Sugar shall submit to the Department a copy of any startup, shutdown, and malfunction (SSM) plan required under 40 CFR 63.6(e)(3) within 30 days of the effective date of this operating permit (if not previously submitted), within 30 days of the compliance date of any new National Emission Standard for Hazardous Air Pollutants (NESHAPs) or Maximum Achievable Control Technology (MACT) standard, and within 30 days of the revision of any such SSM plan, when applicable. The Department requests submittal of such plans in electronic form, when possible.

A.16. On or before February 15 and August 15 of each year, Western Sugar 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 emissions unit. For the reports due by February 15 of each year, Western Sugar may submit a single report, provided that it contains all the information required by Section V.B & V.D. Per ARM 17.8.1207,

> *any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including semiannual monitoring reports), 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."***

A.17. By February 15 of each year, Western Sugar shall submit to the Department the compliance certification required by Section V.B. The annual certification required by Section V.B must include a statement of compliance based on the information available that identifies any observed, documented or otherwise known instance of noncompliance for each applicable requirement. Per ARM 17.8.1207,

> *any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including annual certifications), 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."***

B. EU001 – Erie City Boiler

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
B.1, B.3, B.5, B.6, B.7, B.8	Opacity	20%	Burn Natural Gas Only	Ongoing	Semiannual
B.2, B.4, B.5, B.6, B.7, B.8	Particulate Matter, Fuel Burning	$E = 1.026 * H^{-0.233}$	Method 5	As Required by the Department	

Conditions

B.1. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the Erie City boiler emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

B.2. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the Erie City boiler particulate matter in excess of that allowed by $E = 1.026 * H^{-0.233}$. Where H is the heat input capacity in MMBtu per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

Compliance Demonstration

B.3. While the Erie City boiler is operating, Western Sugar shall burn only natural gas on an ongoing basis to monitor compliance with Section III.B.1. However, this does not preclude the Department from initiating an enforcement action if a Method 9 test indicates that the 20% limit is violated, even if only natural gas is being combusted (ARM 17.8.1213).

B.4. As required by the Department and Section III.A.1, Western Sugar shall perform a Method 5 test or other approved test, in accordance with the Montana Source Test Protocol and Procedures Manual, on the Erie City boiler to monitor compliance with Section III.B.2 (ARM 17.8.1213).

Recordkeeping

B.5. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

Reporting

B.6. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

B.7. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

B.8. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed; and

b. Certification that only natural gas was burned in the Erie City Boiler.

C. EU002 – Boiler House Stack, (3) Riley Boilers

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
C.1, C.2, C.3, C.7, C.10, C.11, C.12, C.13, C.14	SO_2	856.2 lb/3-hrs 6,849.6 lb/day 1,438,416 lb/yr	CEMS	Ongoing	Quarterly
			Method 1-4 and 6/6C	Annually	
C.4, C.5, C.8, C.11, C.12, C.13, C.14	Particulate Matter, Fuel Burning	$E = 1.026 * H^{-0.233}$	Method 5	Every 2 Years	Semiannual
C.6, C.9, C.10, C.11, C.12, C.13, C.14	Opacity	20%	Method 9	Once During Each Campaign	
C.5, C.11, C.15, C.18, C.19	Emission Control Equipment	Operation & Maintenance of Emission Control Equipment	Operation & Maintenance of the Scrubber	Ongoing	Semiannual
C.7, C.12, C.16, C.18, C.19	PM CAM PLAN	ARM 17.8.1506	CAM PLAN Appendix F	Ongoing	Semiannual

Conditions

C.1. Emissions of SO_2 from the boiler house stack shall not exceed 856.2 pounds per three-hour period (Board of Environmental Review (BER) Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

C.2. Emissions of SO_2 from the boiler house stack shall not exceed 6,849.6 pounds per calendar day (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

C.3. Emission of SO_2 from the boiler house stack shall not exceed 1,438,416 pounds per calendar year (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

C.4. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the boiler house stack, particulate matter in excess of that allowed by $E = 1.026 * H^{-0.233}$. Where H is the heat input capacity in MMBtu per hour and E is the maximum allowable particulate emission rate in pounds per MMBtu (ARM 17.8.309).

C.5. Western Sugar shall operate and maintain the wet scrubbers on the Riley Boilers (ARM 17.8.749).

C.6. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the boiler house stack emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

C.7. Western Sugar shall provide a reasonable assurance of compliance with emissions limitations of standards for the anticipated range of operations of the Riley Boilers by following the Compliance Assurance Monitoring (CAM) Plan (Appendix F). The CAM plan, written by Western Sugar in accordance with ARM 17.8.1504, is summarized in Appendix F and is available, in full, upon request by the Department or the facility (ARM 17.8.1504).

Compliance Demonstration

C.8. In accordance with the Stipulation (STIP, Appendix E), Western Sugar shall install, operate and maintain a continuous emissions monitor system (CEMS) to measure the SO_2 concentration in the boiler house stack and a continuous stack flow rate monitor to measure stack gas flow rates. All CEMS shall be operated pursuant to any and all requirements of Exhibit A of the STIP. Monitoring compliance with the emission limitations contained in Section III.C.1, III.C.2, and III.C.3 shall be achieved by using data from the CEMS, with the appropriate equations, and by performing 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 the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106). The annual Relative Accuracy Test Audits (RATAs) required by Sections 6(C) and (D) of the STIP, Exhibit A, may substitute for the annual source test 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 sulfur dioxide (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

C.9. Western Sugar shall perform a Method 5 test or other approved test in accordance with the Montana Source Test Protocol and Procedures Manual every two years to monitor compliance with Section III.C.4. In addition, Western Sugar shall monitor Scrubber performance in accordance with Appendix F, Compliance Assurance Monitoring (ARM 17.8.1213).

C.10. Once during each campaign, Western Sugar shall perform a Method 9 test in accordance with the Montana Source Test Protocol and Procedures Manual (ARM17.8.106). The Method 9 test or other Department approved method test must be used to monitor compliance with the 20% opacity limit. Each observation period shall be a minimum of six minutes unless any one reading is greater than 20%, then the observation period shall be a minimum of 20 minutes or until a violation of the standard has been documented, whichever is a shorter period of time (ARM 17.8.1213).

C.11. Western Sugar shall inspect and maintain the wet scrubber to demonstrate compliance with Section II.C.5. A log of the following parameters shall be maintained on site and submitted to the Department upon request. Log entries shall occur weekly and during any maintenance. All log entries shall include, but are not limited to, the following (ARM 17.8.1213):

a. Date of log entry;

b. Time of log entry;

c. Initials of individual entering information in the log;

d. List specific parameters checked to determine proper operation;

e. Any maintenance activities occurring on the wet scrubber; and

f. Records of control equipment and associated piping/ducts maintenance shall be kept on site.

C.12. Western Sugar shall monitor compliance by following the CAM Plan (Appendix F) (ARM 17.8.1503 and ARM 17.8.1213).

Recordkeeping

C.13. Western Sugar shall maintain on site, all CEMS, including the continuous stack flow rate monitor data (ARM 17.8.1212).

C.14. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

C.15. Western Sugar shall maintain a log on site, as required by Section III.C.11, and shall submit the log to the Department upon request (ARM 17.8.1212).

C.16. Records shall be prepared and data kept in accordance with 40 CFR Part 64 and the CAM Appendix F of this permit (40 CFR 64 and ARM 17.8.1212).

Reporting

C.17. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106, EPA approved SIP, May 2, 2002 and ARM 17.8.1212).

C.18. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212 EPA approved SIP, May 2, 2002).

C.19. The semiannual monitoring report shall provide (ARM 17.8.1212; EPA approved SIP, May 2, 2002):

a. A summary of the results of the last source testing that was performed;

b. Certification that CEMS data and appropriate equations were used in determining compliance with Sections III.C.1, III.C.2, and III.C.3;

c. A summary of repair and maintenance activities;

d. Certification that the continuous stack flow rate monitor was operated and maintained and data were used to determine stack gas flow rates in the quarterly reports;

e. Certification that quarterly reports were submitted to the Department; and

f. Certification of compliance with 40 CRF Part 64 (CAM), Appendix F of this permit.

D. EU003 – Clever-Brooks Boiler

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
D.2, D.3, D.5, D.6, D.7, D.8	Particulate Matter, Fuel Burning	$E = 0.882 * H^{-0.1664}$	Method 5	As Required by the Department	Semiannual
D.1, D.4, D.5, D.6, D.7, D.8	Opacity	40%	Burn Natural Gas Only	Ongoing	

Conditions

D.1. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the Clever-Brooks Boiler emissions that exhibit an opacity of 40% or greater averaged over six consecutive minutes (ARM 17.8.304).

D.2. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the Clever-Brooks Boiler particulate matter in excess of that allowed by $E = 0.882 * H^{-0.1664}$. Where H is the heat input capacity in MMBtu per hour and E is the maximum allowable particulate emission rate in pounds per MMBtu (ARM 17.8.309).

Compliance Demonstration

D.3. As required by the Department and Section III.A.1, Western Sugar shall perform a Method 5 test or other approved test, in accordance with the Montana Source Test Protocol and Procedures Manual, on the Clever-Brooks Boiler, to monitor compliance with Section III.D.2 (ARM 17.8.1213).

D.4. While the Clever-Brooks boiler is operating, Western Sugar shall burn only natural gas on an ongoing basis to monitor compliance with Section III.D.1. However, this does not preclude the Department from initiating an enforcement action if a Method 9 test indicates that the 40% limit is being violated, even if only natural gas is being combusted (ARM 17.8.1213).

Recordkeeping

D.5. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

Reporting

D.6. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

D.7. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

D.8. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed; and

b. Certification that only natural gas was burned in the Clever-Brooks Boiler.

E. EU004 – Pulp Dryers

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
E.1, E.2, E.3, E.7, E.15, E.17, E.19, E.20, E.21	SO_2	88.5 lb/3-hrs 708.0 lb/day 148,680 lb/yr	Install, Operate, and Maintain Fuel Oil Flowmeters	Ongoing	Quarterly
			Method 104 and 6/6C	Annually	
E.4, E.9, E.10, E.16, E.20, E.21	Fuel Oil Sulfur Content	--------	Sampling and Analysis	Daily	
E.5, E.11, E.16, E.20, E.21	Beet Pulp Sulfur Content	--------	Sampling and Analysis	Weekly	Semiannual
E.6, E.12, E.17, E.19, E.20, E.21	Particulate Matter, Industrial Process	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} – 40$	Method 5	Every 2 Years	
E.7, E.13, E.17, E.19, E.20, E.21	Opacity	20%	Method 9	Once During Each Campaign	
E.4, E.9, E.10, E.16, E.20, E.21	Fuel Oil Sulfur Content	--------	Sampling and Analysis	Daily	
E.8, E.14, E.18, E.20, E.21	Pressed Pulp Operational Limit	188,000 tons/rolling 12-Month Period	Recordkeeping	Monthly	
E.9, E.15, E.19	PM CAM Plan	Operation & Maintenance of Emission Control Equipment	Operation & Maintenance of the Scrubber	Ongoing	Semiannual

Conditions

E.1. Combined three hour emissions of SO_2 from the east dryer stack and west dryer stack shall not exceed 88.5 pounds per three-hour period (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

E.2. Combined daily emissions of SO_2 from the east dryer stack and west dryer stack shall not exceed 708.0 pounds per calendar day (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

E.3. Combined annual emissions of SO_2 from the east dryer stack and west dryer stack shall not exceed 148,680 pounds per calendar year (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

E.4. Western Sugar shall determine the sulfur content of the fuel oil used to fire the pulp dryers when fuel oil is the fuel being used to fire the pulp dryers (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

E.5. Western Sugar shall determine the sulfur content of the beet pulp sent to the pulp dryers (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002). The removal of this requirement would be effective only after the Department and EPA approve a SIP revision in which beet pulp sulfur testing no longer is required.

E.6. Western Sugar shall not cause or authorize particulate matter to be discharged from the pulp dryers particulate matter in excess of the amount allowed by ARM 17.8.310. The following equations shall be used to calculate the values:

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 (ARM 17.8.310).

E.7. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the east dryer stack or west dryer stack, emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

E.8. Western Sugar shall limit the total combined throughput for the east dryer and west dryer to 188,000 tons of pressed pulp during any rolling 12-month time period (ARM 17.8.749).

Compliance Demonstration

E.9. Western Sugar shall install, operate, and maintain two in-line fuel oil flowmeters on the fuel oil loop, one immediately upstream from the east dryer furnace and one downstream from the west dryer furnace. In accordance with the Stipulation (STIP, Appendix E), Western Sugar shall monitor compliance with the emission limitations contained in Section III.E.1, III.E.2, and III.E.3 by using: total hourly mass of fuel oil consumed, values taken from the fuel oil flowmeters; daily fuel oil sulfur analysis; the hourly mass of beet pulp feed to the dryers; the weekly beet sulfur analysis; the control efficiency determined in accordance with Section 2(A)(8)(b) of the STIP, Exhibit A; use of the appropriate equations; and by performing annual source testing on the beet dryer stack that is expected to emit the most sulfur dioxide during the campaign. The annual source testing shall be conducted within 30 days after the start of a campaign and shall use EPA approved methods (40 CFR Part 60, Appendix A, Method 1-4 and 6/6C as appropriate for the STIP and Exhibit A) or an equivalent method approved by the Department and EPA, and in accordance with the Montana Source Testing Protocol and Procedures Manual (ARM 17.8.106) (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

E.10. Western Sugar shall conduct daily fuel oil sampling and analyze all fuel oil samples collected for sulfur content in accordance with Method C-1 of Attachment #1 of the STIP when fuel oil is being used as fuel (Appendix E) (BER Order signed on June 12, 1998, SIP approved by EPA on May 2, 2002).

E.11. Western Sugar shall conduct weekly sampling and analysis of the beet pulp fed to the dryers. The percent sulfur for a particular week shall be the percent sulfur from the most recent sample (BER Order signed on June 12, 1998, this requirement is "State Only" until approval of the SIP by the EPA).

E.12. Western Sugar shall perform a Method 5 test or other approved test, in accordance with the Montana Source Test Protocol and Procedures Manual, on the east dryer stack and west dryer stack every two years to monitor compliance with Section III.E.6 (ARM 17.8.1213).

E.13. Western Sugar shall perform a Method 9 test or other approved test, in accordance with the Montana Source Test protocol and Procedures Manual, on the east dryer stack and west dryer stack once during each campaign to monitor compliance with Section III.E.7 (ARM 17.8.1213).

E.14. Western Sugar shall document, by month, the total throughput for the east dryer and the west dryer. By the 25th day of each month, Western Sugar shall sum the total combined throughput for the east dryer and the west dryer during the previous 12 months to verify compliance with the limitation contained in Section III.E.8. A written report of compliance verification, including the previous 12 month total combined throughput, shall be submitted annually to the Department no later than March 1 and may be submitted along with the annual emission inventory (ARM 17.8.749 and 17.8.1213).

Recordkeeping

E.15. Western Sugar shall maintain all CEMS and in-line fuel oil flowmeter data on site (ARM 17.8.1212).

E.16. Western Sugar shall maintain all sampling and analysis data on site (ARM 17.8.1212).

E.17. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

E.18. Western Sugar shall maintain records as required by Sections III.E.14 and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

E.19. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.1212; EPA approved SIP, May 2, 2002).

E.20. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212; EPA approved SIP, May 2, 2002).

E.21. The semiannual monitoring report shall provide (ARM 17.8.1212; EPA approved SIP, May 2, 2002):

a. A summary of the results of the last source testing that was performed;

b. Certification that sampling and analysis of fuel oil and beet pulp was performed as required by Section III.E.10 and III.E.11;

c. Certification that compliance with Sections III.E.1, III.E.2, and III.E.3 was determined as required by Section III.E.9;

d. Certification that CEMS and fuel oil flowmeter data were submitted in the quarterly reports;

e. Certification that quarterly reports were submitted to the Department; and

f. Certification that compliance was maintained with the throughput limit in Section III.E.8.

F. EU005 – Pellet Mill/Conveyor

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
F.1, F.3, F.4, F.5, F.7, F.8, F.9, F.10, F.11, F.12	Opacity	20%	Visual Surveys	Weekly During Each Campaign	Semiannual
			Operate and Maintain Cyclones	Ongoing	
F.2, F.3, F.4, F.6, F.7, F.9, F.10, F.11, F.12	Particulate Matter, Industrial Process	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} – 40$	Method 5	As Required by the Department	
			Operate and Maintain Cyclones	Ongoing	

Conditions

F.1. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the pellet mill/conveyor emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

F.2. Western Sugar shall not discharge into the atmosphere from the pellet mill/conveyor cyclones particulate matter in excess of the amount allowed by ARM 17.8.310. The following equations shall be used to calculate the values:

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 (ARM 17.8.310).

Compliance Demonstration

F.3. Western Sugar shall operate and maintain the multiple cyclones on the pellet mill/conveyor (ARM 17.8.1213).

F.4. The multicyclones shall be maintained and operated in accordance with proper operating procedures to minimize emissions and monitor compliance with the particulate and opacity standards. A log of the following parameters shall be maintained on site and submitted to the Department upon request. Log entries shall occur weekly, whenever the equipment is operating and during maintenance of the equipment. All log entries shall include, but are not limited to, the following (ARM 17.8.1213):

a. Date of log entry;

b. Time of log entry;

c. Initials of individual entering information in the log;

d. List specific parameters checked to determine proper operation;

e. Any maintenance activities occurring on the cyclones; and

f. Records of control equipment and associated piping/ducts maintenance shall be kept on site.

F.5. Once per calendar week during daylight hours, Western Sugar shall visually survey the Pellet Mill Conveyor for any sources of excessive emissions. For the purpose of this survey, excessive emissions are considered to by any visible emissions, which meet or exceed 15% opacity. The person conducting the survey does not have to be an EPA Method 9 certified observer. However, the individual must have been certified as a Method 9 observer within the previous two years of the visual survey being performed. If sources of excessive emissions are identified, Western Sugar shall immediately conduct a Method 9 or take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Western Sugar shall immediately conduct a subsequent visual survey to monitor compliance. The person conducting the visual survey shall record the results of the survey in a log, including any corrective action taken. Conducting a visual survey does not relieve Western Sugar of a liability for a violation determined using Method 9 (ARM 17.8.1213).

F.6. As required by the Department and Section III.A.1, Western Sugar shall perform a Method 5 test or other approved test method, in accordance with the Montana Source Test Protocol and Procedures Manual, on the pellet mill/conveyor cyclone stacks to monitor compliance with Section III.F.2 (ARM 17.8.1213).

Recordkeeping

F.7. Western Sugar shall maintain a log on site, as required by Section III.F.4, and shall submit the log to the Department upon request (ARM 17.8.1212).

F.8. When visual surveys are performed, Western Sugar shall maintain a log to verify that the visual surveys were performed as specified in Section III.F.5. Each log entry must include the date, time, results of the survey, and the observer's initials. If any corrective action is required, the time, date, observer's initials, and any preventative or corrective action taken must be recorded in the log. This log shall be maintained on site and submitted to the Department upon request (ARM 17.8.1212).

F.9. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

Reporting

F.10. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

F.11. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

F.12. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of the last source testing that was performed;

b. Certification of compliance with the logging requirements as required by Section III.F.4;

c. Certification that visual surveys were performed as required in Section III.F.5; and

d. A summary of repair and maintenance activities.

G. EU006 – Pelletizer-Cooler

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
G.1, G.4, G.5, G.6, G.9, G.10, G.11, G.13, G.14, G.15	Opacity	20%	Visual Surveys	Weekly During Each Campaign	Semiannual
			Operate and Maintain Cyclones	Ongoing	
G.2, G.4, G.5, G.7, G.9, G.11, G.13, G.14, G.15	Particulate Matter, Industrial Process	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} – 40$	Method 5	As Required by the Department	
			Operate and Maintain Cyclones	Ongoing	
G.3, G.8, G.12, G.14, G.15	Pellet Operational Limit	75,000 tons/rolling 12-Month Period	Recordkeeping	Monthly	

Conditions

G.1. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the pelletizer-cooler emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

G.2. Western Sugar shall not discharge into the atmosphere from the pelletizer-cooler cyclones particulate matter in excess of the amount allowed by ARM 17.8.310. The following equations shall be used to calculate the values:

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 (ARM 17.8.310).

G.3. Western Sugar shall limit the total throughput to the pelletizer cooler to 75,000 tons of pellets during any rolling 12-month time period (ARM 17.8.749).

Compliance Demonstration

G.4. Western Sugar shall operate and maintain the cyclones on the pelletizer-cooler (ARM 17.8.1213).

G.5. The pelletizer-cooler cyclones shall be maintained and operated in accordance with proper operating procedures to minimize emissions and monitor compliance with the particulate and opacity standards. A log of the following parameters shall be maintained on site and submitted to the Department upon request. Log entries shall occur weekly, whenever the equipment is operating and during maintenance of the equipment. All log entries shall include, but are not limited to, the following (ARM 17.8.1213):

a. Date of log entry;

b. Time of log entry;

c. Initials of individual entering information in the log;

d. List specific parameters checked to determine proper operation;

e. Any maintenance activities occurring on the cyclones; and

f. Records of control equipment and associated piping/ducts maintenance shall be kept on site.

G.6. Once per calendar week during daylight hours, Western Sugar shall visually survey the pelletizer cooler for any sources of excessive emissions. For the purpose of this survey, excessive emissions are considered to by any visible emissions, which meet or exceed 15% opacity. The person conducting the survey does not have to be an EPA Method 9 certified observer. However, the individual must have been certified as a Method 9 observer within the previous two years of the visual survey being performed. If sources of excessive emissions are identified, Western Sugar shall immediately conduct a Method 9 or take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Western Sugar shall immediately conduct a subsequent visual survey to monitor compliance. The person conducting the visual survey shall record the results of the survey in a log, including any corrective action taken. Conducting a visual survey does not relieve Western Sugar of a liability for a violation determined using Method 9 (ARM 17.8.1213).

G.7. As required by the Department and Section III.A.1, Western Sugar shall perform a Method 5 test or other approved test method, in accordance with the Montana Source Test Protocol and Procedures Manual, on the pelletizer-cooler cyclone stacks to monitor compliance with Section III.G.2 (ARM 17.8.1213).

G.8. Western Sugar shall document, by month, the total throughput for the pelletizer cooler. By the 25th day of each month, Western Sugar shall sum the total throughput of the pelletizer cooler during the previous month. The monthly information will be used to verify compliance with the rolling 12-month limitation in Section II.G.3. The information for each of the previous months shall be submitted along with the annual emission inventory (ARM 17.8.749).

Recordkeeping

G.9. Western Sugar shall maintain a log on site, as required by Section III.G.4, and submit it to the Department upon request (ARM 17.8.1212).

G.10. When visual surveys are performed, Western Sugar shall maintain a log to verify that the visual surveys were performed as specified in Section III.G.6. Each log entry must include the date, time, results of the survey, and the observer's initials. If any corrective action is required, the time, date, observer's initials, and any preventative or corrective action taken must be recorded in the log. This log shall be maintained on site and submitted to the Department upon request (ARM 17.8.1212).

G.11. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

G.12. Western Sugar shall maintain records as required by Sections III.G.8 and submit the information to the Department upon request (ARM 17.8.1212).

Reporting

G.13. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

G.14. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

G.15. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of the results of the last source testing that was performed;

b. Certification of compliance with the logging requirements as required by Section III.G.5;

c. Certification that visual surveys were performed as required in Section III.G.6;

d. A summary of repair and maintenance activities; and

e. Certification that compliance was maintained with the throughput limit in Section III.G.3.

H. EU007 – (4) Granulators

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
H.1, H.3, H.4, H.5, H.7, H.8, H.9, H.10, H.11, H.12	Opacity	40%	Visual Surveys	Weekly during each campaign	Semiannual
			Operate and Maintain Scrubbers/ Baghouses	Ongoing	
H.2, H.3, H.4, H.6, H.7, H.9, H.10, H.11. H.12	Particulate Matter, Industrial Process	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} – 40$	Method 5	As required by the Department	
			Operate and Maintain Scrubbers/ Baghouses	Ongoing	

Conditions

H.1. Western Sugar shall not cause or authorize to be discharged into the atmosphere, from the granulator stacks, emissions that exhibit an opacity of 40% or greater averaged over six consecutive minutes (ARM 17.8.304).

H.2. Western Sugar shall not discharge into the atmosphere, from the granulator stacks, particulate matter in excess of the amount allowed by ARM 17.8.310. The following equations shall be used to calculate the emission values:

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 (ARM 17.8.310).

Compliance Demonstration

H.3. Western Sugar shall operate and maintain the two wet scrubbers and the two baghouses on the granulators (ARM 17.8.1213).

H.4. The granulator wet scrubbers and baghouses shall be maintained and operated in accordance with proper operating procedures to minimize emissions and monitor compliance with the particulate and opacity standards. A log of the following parameters shall be maintained on site and submitted to the Department upon request. Log entries shall occur weekly, whenever the equipment is operating and during maintenance of the equipment (ARM 17.8.1213).

a. Date of log entry;

b. Time of log entry;

c. Initials of individual entering information in the log;

d. List specific parameters checked to determine proper operation;

e. Any maintenance activities; and

f. Records of control equipment and associated piping/ducts maintenance shall be kept on site.

H.5. Once per calendar week during daylight hours, Western Sugar shall visually survey the granulators for any sources of excessive emissions. For the purpose of this survey, excessive emissions are considered to by any visible emissions, which meet or exceed 30% opacity. The person conducting the survey does not have to be an EPA Method 9 certified observer. However, the individual must have been certified as a Method 9 observer within the previous two years of the visual survey being performed. If sources of excessive emissions are identified, Western Sugar shall immediately conduct a Method 9 or take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Western Sugar shall immediately conduct a subsequent visual survey to monitor compliance. The person conducting the visual survey shall record the results of the survey in a log, including any corrective action taken. Conducting a visual survey does not relieve Western Sugar of a liability for a violation determined using Method 9 (ARM 17.8.1213).

H.6. As required by the Department and Section III.A.1, Western Sugar shall perform a Method 5 test or other approved testing method, in accordance with the Montana Source Test Protocol and Procedures Manual, on the granulator wet scrubber and baghouse stacks, to monitor compliance with Section III.H.2 (ARM 17.8.1213).

Recordkeeping

H.7. Western Sugar shall maintain a log on site, as required by Section III.H.4, and submit the log to the Department upon request (ARM 17.8.1212).

H.8. When visual surveys are performed, Western Sugar shall maintain a log to verify that the visual surveys were performed as specified in Section III.H.5. Each log entry must include the date, time, results of the survey, and the observer's initials. If any corrective action is required, the time, date, observer's initials, and any preventative or corrective action taken must be recorded in the log. This log shall be maintained on site and submitted to the Department upon request (ARM 17.8.1212).

H.9. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

Reporting

H.10. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

H.11. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

H.12. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed;

b. Certification of compliance with the logging requirements as required by Section III.G.4;

c. Certification that visual surveys were performed as required in Section III.G.5; and

d. A summary of repair and maintenance activities.

I. EU008 – Lime Slaker Vent

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
I.1, I.3, I.5, I.6, I.7, I.8, I.9	Opacity	20%	Visual Surveys	Weekly During Each Campaign	Semiannual
I.2, I.4, I.6, I.7, I.8, I.9	Particulate Matter, Industrial Process	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} – 40$	Method 5	As Required by the Department	

Conditions

I.1. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the lime slaker vent emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

I.2. Western Sugar shall not discharge into the atmosphere from the lime slaker building vent particulate matter in excess of the amount allowed by ARM 17.8.310. The following equations shall be used to calculate the emission values:

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 (ARM 17.8.310).

Compliance Demonstration

I.3. Once per calendar week during daylight hours, Western Sugar shall visually survey the slaker building vent for any sources of excessive emissions. For the purpose of this survey, excessive emissions are considered to by any visible emissions, which meet or exceed 15% opacity. The person conducting the survey does not have to be an EPA Method 9 certified observer. However, the individual must have been certified as a Method 9 observer within the previous two years of the visual survey being performed. If sources of excessive emissions are identified, Western Sugar shall immediately conduct a Method 9 or take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Western Sugar shall immediately conduct a subsequent visual survey to monitor compliance. The person conducting the visual survey shall record the results of the survey in a log, including any corrective action taken. Conducting a visual survey does not relieve Western Sugar of a liability for a violation determined using Method 9 (ARM 17.8.1213).

I.4. As required by the Department and Section III.A.1, Western Sugar shall perform a Method 5 test or other approved test in accordance with the Montana Source Test Protocol and Procedures Manual on the slaker building vent to monitor compliance with Section III.I.2 (ARM 17.8.1213).

Recordkeeping

I.5. When visual surveys are performed, Western Sugar shall maintain a log to verify that the visual surveys were performed as specified in Section III.I.3. Each log entry must include the date, time, results of the survey, and the observer's initials. If any corrective action is required, the time, date, observer's initials, and any preventative or corrective action taken must be recorded in the log. This log shall be maintained on site and submitted to the Department upon request (ARM 17.8.1212).

I.6. All compliance source test recordkeeping shall be performed in accordance with the test method used and the Montana Source Test Protocol and Procedures Manual, and shall be maintained on site (ARM 17.8.106 and ARM 17.8.1212).

Reporting

I.7. Any compliance source test reports must be submitted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.106 and ARM 17.8.1212).

I.8. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements.

I.9. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed; and

b. Certification that visual surveys were performed as required in Section III.I.3.

J. EU009 – Burnt Lime Collector

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
J.1, J.3, J.4, J.5, J.6	Opacity	20%	Inspection and Maintenance Log of Baghouse	Weekly and During Any Maintenance	Semiannual
J.2, J.3, J.4, J.5, J.6	Particulate Matter, Industrial Process	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} – 40$			

Conditions

J.1. Western Sugar shall not cause or authorize to be discharged into the atmosphere from the burnt lime collector emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

J.2. Western Sugar shall not discharge into the atmosphere from the burnt lime baghouse particulate matter in excess of the amount allowed by ARM 17.8.310. The following equations shall be used to calculate the emission values:

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 (ARM 17.8.310).

Compliance Demonstration

J.3. The dust filter baghouse shall be maintained and operated in accordance with proper operating procedures to minimize emissions and monitor compliance with the particulate and opacity standards. A log of the following parameters shall be maintained on site and submitted to the Department upon request. Log entries shall occur weekly, whenever the equipment is operating and during maintenance of the equipment (ARM 17.8.1213).

a. Date of log entry;

b. Time of log entry;

c. Initials of individual entering information in the log;

d. List specific parameters checked to determine proper operation;

e. Any maintenance activities; and

f. Records of control equipment and associated piping/ducts maintenance shall be kept on site.

Recordkeeping

J.4. Western Sugar shall maintain a log on site as required by Section III.J.3 and submit the log to the Department upon request (ARM 17.8.1212).

Reporting

J.5. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

J.6. The semiannual monitoring report shall provide certification that the log was maintained as required by Section III.J.3 (ARM 17.8.1212).

K. EU010 – Truck Hauling, Fugitives

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
K.1, K.3, K.4, K.5, K.6	Opacity	20%	Visual Surveys	Weekly	Semiannual
K.1, K.2, K.3, K.4, K.5, K.6	Opacity	Reasonable Precaution	Preventative or Corrective Action	As Necessary	

Conditions

K.1. Western Sugar 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 from any stationary source shall not exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.308).

K.2. Western Sugar shall treat all unpaved portions of the access roads, parking lots, and the general plant area with fresh water and/or chemical dust suppressant, as necessary, to maintain compliance with the reasonable precautions limitation (ARM 17.8.749).

Compliance Demonstration

K.3. Once per calendar week during each campaign and during daylight hours, Western Sugar shall visually survey the truck-hauling fugitives for any sources of excessive emissions. For the purpose of this survey, excessive emissions are considered to by any visible emissions, which meet or exceed 15% opacity. The person conducting the survey does not have to be an EPA Method 9 certified observer. However, the individual must have been certified as a Method 9 observer within the previous two years of the visual survey being performed. If sources of excessive emissions are identified, Western Sugar shall immediately conduct a Method 9 or take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Western Sugar shall immediately conduct a subsequent visual survey to monitor compliance. The person conducting the visual survey shall record the results of the survey in a log, including any corrective action taken. Conducting a visual survey does not relieve Western Sugar of a liability for a violation determined using Method 9 (ARM 17.8.1213).

Recordkeeping

K.4. When visual surveys are performed, Western Sugar shall maintain a log to verify that the visual surveys were performed as specified in Section III.K.3. Each log entry must include the date, time, results of survey, and observer's initials. If any corrective action is required, the time, date, observer's initials, and any preventative or corrective action taken must be recorded in the log. This log shall be maintained on site and submitted to the Department upon request (ARM 17.8.1212).

Reporting

K.5. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

K.6. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. Certification that the visual surveys were performed and logged as specified by Section III.K.3 and III.K.4;

b. Certification that a log of corrective actions was maintained as specified by Section III.K.4; and

c. Identification of any instances of excessive fugitive emissions and the corrective action taken.

L. EU017 – Warehouse Sugar Dust Collector

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
L.1, L.3, L.4, L.5, L.6	Opacity	20%	Inspection and Maintenance Log of Baghouse	Weekly and During Any Maintenance	Semiannual
L.2, L.3, L.4, L.5, L.6	Particulate Matter, Industrial Process	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} - 40$			

Conditions

L.1. Western shall not cause or authorize to be discharged into the atmosphere from the Warehouse Sugar Dust Collector, emissions that exhibit an opacity of 20% or greater averaged over six consecutive minutes (ARM 17.8.304).

L.2. Western shall not cause, suffer, allow or permit to be discharged into the atmosphere, from the Warehouse Sugar Dust Collector, particulate matter in excess of the amount allowed by ARM 17.8.310. The following equations shall be used to calculate the values:

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.

Compliance Demonstration

L.3. The dust collector baghouse shall be maintained and operated in accordance with proper operating procedures to minimize emissions and ensure compliance with the particulate and opacity standards. A log of the following parameters shall be maintained on site and submitted to the Department upon request. Log entries shall occur weekly, whenever the equipment is operating and during maintenance of the equipment (ARM 17.8.1213).

a. Date of log entry;

b. Time of log entry;

c. Initials of individual entering information in the log;

d. List specific parameters checked to determine proper operation;

e. Any maintenance activities; and

f. Records of control equipment and associated piping/ducts maintenance shall be kept on site.

Recordkeeping

L.4. Western Sugar shall maintain a log on site as required by Section III.L.3 and submit the log to the Department upon request (ARM 17.8.1212).

Reporting

L.5. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

L.6. The semiannual monitoring report shall provide certification that the log was maintained as required by Section III.L.3 (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 emissions 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, which are administrated by the Air Resources Management Bureau of the Department of Environmental Quality.

Rule Citation	Reason
40 CFR 57	This facility is not in this source category.
40 CFR 60, Subparts C, Ca, Cb, Cc 40 CFR 60, Subparts D, Da, Db, Dc 40 CFR 60, Subparts E-J 40 CFR 60, Subparts K, Ka, Kb 40 CFR 60, Subparts L-X 40 CFR 60, Subparts Z 40 CFR 60, Subparts AA-EE 40 CFR 60, Subparts GG-HH 40 CFR 60, Subparts KK-NN 40 CFR 60, Subparts PP-XX 40 CFR 60, Subparts AAA-DDD 40 CFR 60, Subparts FFF-LLL 40 CFR 60, Subparts NNN-QQQ 40 CFR 60, Subparts RRR-WWW 40 CFR 61, Subparts B-F 40 CFR 61, Subparts H-L 40 CFR 61, Subparts N-R 40 CFR 61, Subparts T 40 CFR 61, Subparts V-W 40 CFR 61, Subparts Y 40 CFR 61, Subparts BB 40 CFR 61, Subparts FF	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 63	This requirement is not applicable because this facility does not have emissions, emission units, or regulated substance as defined in this regulation or has not made changes at the facility that would trigger this requirement.
40 CFR 72-78	These requirements are not applicable because this facility is not in this source category.
ARM 17.8.610 ARM 17.8.321 ARM 17.8.323 ARM 17.8.331 ARM 17.8.332 ARM 17.8.333 ARM 17.8.334	These rules do not apply because this facility is not in this source category.
ARM 17.8.316 ARM 17.8.320 ARM 17.8.341 ARM 17.8.342	These rules do not apply because this facility does not have these emissions or emission units.

B. Emission Units

The permit application identified applicable requirements. Non-applicable requirements for individual or specific emission units were not listed. 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)-(d)

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 February 15 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 identification of the method(s) or other means used by the owner or operator for determining the status of compliance with each term and condition during the certification period, consistent with ARM 17.8.1212;

   c. The status of compliance with each term and condition for the period covered by the certification, *including whether compliance during the period was continuous or intermittent* (based on the method or means identified in ARM 17.8.1213(7)(c)(ii), as described above); and

   d. 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; and

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 five 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 February 15 and August 15 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. The monitoring report submitted on February 15 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 August 15 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; and

   d. The permittee submitted notice of the emergency to the Department within two 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; and

   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; and

   e. The facility provides the administrator and the Department with written notification at least seven 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 Sec. 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; and

   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)

This permit may be reopened and revised under the following circumstances:

1. Additional applicable requirements under the FCAA become applicable to the facility when the permit has a remaining term of three 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);

2. 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;

3. 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; or

4. 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 five 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 six 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. Montana Air Quality Permits
ARM 17.8, Subchapter 7, Permit, Construction and Operation of Air Contaminant Sources §745 and 764 (ARM 17.8.745(1) and 764(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 17.8.744(1)(a)-(k).

2. The permittee shall comply with ARM 17.8.743, 744, 745, 748, and 764.

3. ARM 17.8.745(1) 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 17.8.745(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; or

   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 17.8.745(1) 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 17.8.745(1) (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; and

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

Appendix A INSIGNIFICANT EMISSION UNITS

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

Pursuant to ARM 17.8.1201(22)(a), an insignificant emission unit means any activity or emissions unit located within a source that: (i) has a potential to emit less than five 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 Sec. 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 Western Sugar. Because there are no requirements to update such a list, the emission units and/or activities may change from those specified in the table.

Emissions Unit ID	Description
IEU001	Lime Kiln
IEU002	Coal Handling
IEU003	Limestone Handling
IEU004	Coke Handling

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Appendix B 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 Western Sugar;

(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 that 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 emission 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.

"Excess emissions" means any visible emissions from a stack or source, viewed during the visual surveys, that meets or exceeds 15% opacity (or 30% opacity if associated with a 40% opacity limit) during normal operating conditions.

"Emissions 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 Sec. 112(b) of the FCAA.

"Non-federally enforceable requirement" means the following as they apply to emission 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 Sec. 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 Sec. 7412(e) of the FCAA;

(ii) Any pollutant for which the requirements of Sec. 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:

ARM	Administrative Rules of Montana
ASTM	American Society of Testing Materials
BACT	Best Available Control Technology
BDT	bone dry tons
BTU	British Thermal Unit
CFR	Code of Federal Regulations
CO	carbon monoxide
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	emissions unit
FCAA	Federal Clean Air Act
gr	grains
HAP	hazardous air pollutant
IEU	insignificant emissions unit
Mbdft	thousand board feet
Method 5	40 CFR 60, Appendix A, Method 5
Method 9	40 CFR 60, Appendix A, Method 9
MMbdft	million board feet
MMBTU	million British Thermal Units
NOx	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
QIP	Quality Improvement Plan
scf	standard cubic feet
SIC	Source Industrial Classification
SIP	State Implementation Plan
SO_2	sulfur dioxide
SOx	oxides of sulfur
tpy	tons per year
U.S.C.	United States Code
VE	visible emissions
VOC	volatile organic compound

Appendix C NOTIFICATION ADDRESSES

Compliance Notifications:

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

United States EPA
Air Program Coordinator
Region VIII, Montana Office
10 W. 15th Street, Suite 3200
Helena, MT 59626

Permit Modifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air Resources 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 300
Denver, CO 80202-2466

Appendix D AIR QUALITY INSPECTOR INFORMATION

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

1. **Direction to Plant:**

   Western Sugar's Billings plant is located in the city limits of Billings Montana. When traveling on Interstate 90, take the 27th Street exit. Travel northwest until intersecting State Avenue and turn west. The physical address is 3020 State Avenue, Billings, Montana 59107.

2. **Safety Equipment Required:**

   Appropriate personal protective equipment shall be used by anyone coming into the factory. Hardhats, safety glasses with side shields, and sturdy leather footwear are required (boots are recommended but not required). Earplugs are recommended for general plant use, and must be worn in designated areas. Hairnets and beard-nets (supplied by Western Sugar) are required on the sugar end of the factory and in the warehouse and packaging areas.

3. **Facility Plot Plan:**

   The facility plot plan was submitted as part of the Title V Operating Permit application on June 7, 1996.

Appendix E STIPULATION

Although the hard copy of Appendix E has been removed from the permit, the contents of Appendix E, Stipulation, remain as applicable requirements as stated in the Title V Operating Permit #OP2912-04. To receive a hard copy of the Stipulation, please contact one of the following:

Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
1520 East 6th Avenue
P.O. Box 200901
Helena, MT 59620-0901
Bureau Telephone #: (406) 444-3490

Or

The Western Sugar Cooperative
3020 State Avenue
Billings, MT 59107

Appendix F Compliance Assurance Monitoring (CAM)

1. **Emitting Unit:** Boiler House Stack (Three 148 MMBtu/hr (ea.) Riley coal-fired Boilers (EU0002))
   Pollutant: PM
   Control Device: Venturi Wet Scrubbers (2)
   Emission Limit: $E=1.026*H^{-0.233}$
   Monitoring Approach: Key elements of the monitoring approach for this CAM applicable emitting unit are contained in Table I. A complete CAM plan is contained in Western Sugar's Title V Operating Permit Renewal Application and is on file with the Department. Complete copies of the CAM plan are available from the Department upon request.

Table I	
General Criteria	
Indicator	Scrubber water flow to each scrubber.
Measurement Approach	Water flow measured by orifice plates with high and low points connected to a differential pressure transmitter.
Indicator Range	Scrubber water flow is set at 250 gallons per minute (gpm) to each scrubber. The low flow alarm is set at 185 gpm and the high flow alarm is set at 295 gpm.
QIP Threshold	Water flow will be maintained between 150 and 330 gpm. If the high or low range alarms sound, corrective action will be taken.
Performance Criteria	
Data Representativeness	The orifice plates (minimum accuracy of 5%) are located on the pipeline to each scrubber and transmitters provide the flow information to the control room.
Verification of Operational Status	The boiler control panel shows the flow values.
Quality Assurance/Quality Control	The orifice plates are inspected annually with maintenance performed as necessary.
Monitoring Frequency	The flow is measured continuously.
Data Collection Procedure	The flow is displayed continuously and recorded if the high or low flow alarms go off.

2. **Emitting Unit:** Pulp Dryers (EU0004)
   Pollutant: PM
   Control Device: Venturi Wet Scrubbers (2)
   Emission Limit: $E = 4.10 * P^{-0.67}$ (Where $p < 30$ TPH) and $E = 55.0 * P^{0.11} - 40$ (Where $p > 30$ TPH)
   Monitoring Approach: Key elements of the monitoring approach for this CAM applicable emitting unit are contained in Table II. A complete CAM plan is contained in Western Sugar's Title V Operating Permit Renewal Application and is on file with the Department. Complete copies of the CAM plan are available from the Department upon request.

Table II	
General Criteria	
Indicator	Scrubber water flow to each scrubber.
Measurement Approach	Water flow measured by a flow meter on the water pipeline to the pulp dryer scrubbers.
Indicator Range	To be determined during 10/06 stack test with an updated CAM Plan submitted within 60 days of the stack test.
QIP Threshold	Water flow will be maintained within the acceptable range (to be determined during 10/06 stack test) and corrective action will be taken within 24 hours if the water flow is outside the range.
Performance Criteria	
Data Representativeness	The flow measuring devices will be located on the water lines to the scrubbers.
Verification of Operational Status	To be determined depending upon device selected.
Quality Assurance/Quality Control	Intercampaign inspection and maintenance.
Monitoring Frequency	To be determined depending upon the flow meter and means of recording selected.
Data Collection Procedure	To be determined depending upon equipment selected selected.