June 30, 2016

Blake Bills, Plant Manager
Graymont Western U.S., Inc. – Indian Creek Facility
P.O. Box 550
Townsend, MT 59644

RE: Decision Title V Operating Permit #OP1554-10

Dear Mr. Bills:

The Department of Environmental Quality has prepared the enclosed Decision Operating Permit #OP1554-10, for Graymont Western U.S., Inc., located in the SW¼ of Section 28, Township 7 North, Range 1 East, Broadwater County, Montana. Please review the cover page of the attached permit for information pertaining to the action taking place on Permit #OP1544-10.

If you have any questions, please contact John P. Proulx, the permit writer, at (406) 444-1277 or by email at jproulx@mt.gov.

Sincerely,

Julie Merkel
Permitting Services Section Supervisor
Air Quality Bureau
(406) 444-3626

John P. Proulx
Environmental Science Specialist
Air Quality Bureau
(406) 444-1277

JM: JP
Enclosure
cc: Robert Duraski, US EPA Region VIII 8P-AR
Bob Gallagher, USEPA Region 8 – Montana Operations

State of Montana
Department of Environmental Quality
Helena, Montana 59620

AIR QUALITY OPERATING PERMIT NUMBER OP1554-10

Administrative Amendment Received: 6/20/ 2016
Application Deemed Administratively Complete: 6/21/2016
Application Deemed Technically Complete: 6/21/2016
AFS Number: 007-0002A

Date of Decision: 06/30/2016
Effective Date: 08/02/2016
Expiration Date: 02/09/2018
Renewal Application Due Date: 08/09/2017

In accordance with the Montana Code Annotated (MCA) 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*.,

Graymont Western U.S. Inc.
SW¼ of Section 28, Township 7 North, Range 1 East, in Broadwater County, Montana
Indian Creek Facility
P.O. Box 550
Townsend, MT 59644

hereinafter referred to as "Graymont", 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, Graymont 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 which 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.

Permit Issuance and Appeal Process: In accordance with Section 75-2-218, MCA, 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 June 30, 2016. The decision may be appealed to the Board of Environmental Review (Board) by filing a request for a hearing within 30 days after the date of decision. The filing of a request for hearing does not stay the Department's decision, unless the Board orders a stay upon receipt of a petition and a finding that a stay is appropriate under Section 75-2-218(6)(b), MCA. If no stay is ordered, the Department's decision on the application is final 30 days after the decision is made and the Department will send notification and a final permit cover page to be attached to this document stating that the permit is final. Questions regarding the final issuance date and status of appeals should be directed to the Department at (406) 444-3490.

Montana Air Quality Operating Permit
Department of Environmental Quality

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SECTION I GENERAL INFORMATION

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

Company Name: Graymont Western U.S., Inc. – Indian Creek Facility

Mailing Address: P.O. Box 550

City: Townsend **State**: Montana **Zip**: 59644

Plant Location: 4.5 miles west of Townsend, Montana, on Indian Creek Road within the SW¼ of Section 28, Township 7 North, Range 1 East, in Broadwater County, Montana. UTM – Zone 12, Easting: 542.6 km, Northing: 5130.3 km.

Responsible Official/Facility Contact: Blake Bills, Plant Manager: **Phone**: (406) 266-5221
Email: bbills@graymont.com

Primary SIC Code: 3274

Nature of Business: Lime Manufacturing

Description of Process:

The production of lime begins in the quarry. The limestone rock is primarily calcium carbonate ($CaCO_3$) with the possibility of some dolomite ($CaMg(CO_3)_2$). The limestone is blasted, loaded onto trucks, and delivered to the primary crusher where the ore is sized. The crushed limestone is then screened for oversize material and material smaller than what is suitable for kiln feed. Undersize material is rejected to waste piles while oversize material is returned to the crusher. After the rock is crushed and screened, the raw limestone is delivered to a stockpile area for reclaiming at the plant.

At the processing plant, the limestone is conveyed from the reclaim pile to the stone dressing screen. This process simply re-screens the product for undersize material. From the screen, the limestone is conveyed directly to the kiln pre-heater system. The pre-heaters use heat from the exiting kiln gases to warm the limestone prior to introduction into the kilns.

The Graymont Western U.S., Inc., - Indian Creek Facility has two kilns, each rated for 500 tons per day of lime product. Each kiln is approximately 150 feet long and 12 feet in diameter. The kilns are inclined from the horizontal with the stone inlet at the highest point. The kilns rotate as a burner heats the limestone. When limestone temperatures exceed 1650°F the limestone calcines according to the following equation:

$$CaCO_3 + \text{Heat} \leftrightarrow CaO + CO_2(g)$$

Lime product from the kilns is cooled, crushed, screened, and finally stored in silos or loaded into trucks for shipment. A portion of the lime product is also diverted to a hydrating process where water is added to produce calcium hydroxide ($Ca(OH)_2$).

The kilns and pre-heaters can be fired with coal, syncoal, and petroleum coke. These products are stored in silos and/or stockpiles prior to being crushed (pulverized) and subsequently fed into the kiln heating process.

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	Quarry Blasting	Work Practices
EU002	Quarry Drilling	Skirting and Water Spray and/or Cyclone and Fabric Filter
EU003	Wind Erosion - Stockpiles	Water
EU004	Fugitive Emissions – Disturbed Areas	Water and/or Chemical Dust Suppressant and/or Re-Vegetation, Coverings
EU005	Fugitive Emissions – Haul Roads	Water and/or Chemical Dust Suppressant
EU006	Limestone Dumping and Primary Crushing	Water and/or Baghouse
EU007	Limestone Screening - Quarry	Baghouse
EU008	Raw Material Transfer and Stacker	Water
EU009	Limestone Dressing, Screening and Conveying	Water and/or Baghouse
EU011	Lime Kiln #1	Baghouse
EU012	Lime Kiln #2	Baghouse
EU013	Kiln Dust Storage (baghouse) and Handling	Baghouse
EU014	Lime Crushing, Screening and Transfer	Baghouse
EU015	Lime Product Loadout	Baghouse
EU016	Railroad Lime Loadout	Baghouse
EU017	Railroad Unload	Baghouse
EU018	Lime Hydrator Surge Bin	Baghouse
EU019	Lime Hydrator	Baghouse
EU020	Hydrated Lime Pulverizing, Storage, and Transfer	Baghouse
EU021	Hydrated Lime Loadout	2 Baghouses
EU022	Coal Unloading Handling and Storage	Baghouse (on storage)
EU023	Coal, Syncoal, Petroleum Coke Handling and Blending	Baghouse
EU024	Coal, Syncoal, Petroleum Coke Crushing and Handling	Baghouse
EU025	Fuel Use – Diesel Fuel	None
EU026	Fuel Use – Gasoline	None

SECTION III. PERMIT CONDITIONS

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

A. Facility-Wide

Conditions	Rule Citation	Rule Description	Pollutant/Parameter	Limit
A.1	ARM 17.8.105	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	ARM 17.8.342	NESHAPs General Provisions	SSM Plans	Submittal
A.15	ARM 17.8.1211(1)(c) and 40 CFR Part 98	Greenhouse Gas Reporting	Reporting	-------
A.16	ARM 17.8.1212	Reporting Requirements	Prompt Deviation Reporting	-------
A.17	ARM 17.8.1212	Reporting Requirements	Compliance Monitoring	-------
A.18	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 test, 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 regular inspection by the compliance inspector.

A.2. Pursuant to ARM 17.8.304(1), Graymont shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.3. Pursuant to ARM 17.8.304(2), Graymont shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.4. Pursuant to ARM 17.8.308(1), Graymont 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 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.5. Pursuant to ARM 17.8.308(2), Graymont 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, Graymont 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 6 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, Graymont 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, Graymont 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), Graymont shall not burn liquid or solid fuels containing sulfur in excess of 1 pound per million BTU fired, unless otherwise specified by rule or in this permit.

A.10. Pursuant to ARM 17.8.322(5), Graymont shall not burn any gaseous fuel containing sulfur compounds in excess of 50 grains per 100 cubic feet of gaseous fuel, calculated as hydrogen sulfide at standard conditions, unless otherwise specified by rule or in this permit.

A.11. Pursuant to ARM 17.8.324(3), Graymont 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, Graymont 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, Graymont 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 ARM 17.8.342 and 40 CFR 63.6, Graymont 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.15. Pursuant to ARM 17.8.1211(1)(c) and 40 CFR Part 98, Graymont shall comply with requirements of 40 CFR Part 98 – Mandatory Greenhouse Gas Reporting, as applicable (ARM 17.8.1211(1)(c), NOT an applicable requirement under Title V).

A.16. Graymont shall promptly report deviations from permit requirements including those attributable to upset conditions, as upset is defined in the permit. To be considered prompt, deviations shall be reported to the Department using the schedule and content as described in Section V E(unless otherwise specified in an applicable requirement) (ARM 17.8.1212).

A.17. On or before February 15 and August 15 of each year, Graymont 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, Graymont 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.18. By February 15 of each year, Graymont 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 which 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, EU002, EU003, EU004, EU005 – QUARRY OPERATIONS***
Quarry Blasting; Quarry Drilling; Wind Erosion – Stockpiles; Fugitive Emissions – Disturbed Areas; Fugitive Emissions – Haul Roads.

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
B.1, B.9, B.14, B.20, B.21, B.22	Opacity	20%	Method 9 Or	Semiannual	Semiannual
			Visual Surveys	Biweekly	
B.2, B.9, B.10, B.11, B.14, B.16, B.21, B.22	Opacity	Reasonable Precautions	Treatment	As Necessary	Semiannual
			Visual Surveys	Biweekly	
B.3, B.10, B.11, B.16, B.17, B.21, B.22	Opacity	Reasonable Precautions	Treatment	As Necessary	Semiannual
B.4, B.12, B.15, B.17, B.21, B.22,	Blast Overshooting	Prevention	Recordkeeping	Ongoing	Semiannual
B.5, B.11, B.12, B.17, B.18, B.19, B.21, B.22	Quarry Drilling	Skirting and Water Spray or Skirting and Fabric Filter Control	Recordkeeping	Ongoing	Semiannual
B.6, B.12, B.18, B.19 B.21, B.22	Fall Distance	Quarry Materials	Recordkeeping	Ongoing	Semiannual
B.7, B.12, B.18, B.19, B.21, B.22	Fall Distance	Crushed Limestone	Recordkeeping	Ongoing	Semiannual
B.8, B.12, B.13, B.17, B.18, B.19, B.21, B.22	Fugitive Emissions – Disturbed Areas	Stabilize All Disturbed Areas	Stabilization and Maintenance/ Recordkeeping	Ongoing	Semiannual

Conditions

B.1. Graymont shall not cause or authorize to be discharged into the atmosphere, from any source, visible emissions that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304 and ARM 17.8.752).

B.2. Graymont 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 6 consecutive minutes unless otherwise specified by rule or in this permit (ARM 17.8.308(1)).

B.3. Graymont 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 (ARM 17.8.308(2)).

B.4. Graymont shall conduct quarry blasting in such a way as to prevent overshooting (ARM 17.8.749).

B.5. Quarry drilling shall be conducted with skirting and water sprays or skirting with cyclone and fabric filter control (ARM 17.8.749).

B.6. Fall distance shall be minimized during transfer of topsoil, overburden and limestone removal, and during transfer of all materials from front-end loaders to trucks (ARM 17.8.752).

B.7. Fall distance of crushed limestone to storage pile shall be minimized (40 CFR 52.21).

B.8. All disturbed or exposed areas shall be stabilized with chemicals, mulch, or re-vegetation (ARM 17.8.749).

Compliance Demonstration

B.9. Graymont shall either conduct a semiannual Method 9 source test or once every two calendar weeks, a visual survey of the visible emissions during Quarry Operations. If visible emissions are observed during the visual survey, Graymont must conduct a Method 9 source test. The Method 9 source test must begin within one hour of any observation of visible emissions. If visible emissions meet or exceed 15% opacity based on the Method 9 source test, Graymont shall immediately take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Graymont shall immediately conduct a subsequent visual survey (and subsequent Method 9 source test if visible emissions remain) to monitor compliance. The person conducting the visual survey shall record the results of the survey (including the results of any Method 9 source test performed) and any corrective action taken in a log. Conducting a visual survey does not relieve Graymont of the liability for a violation determined using Method 9 (ARM 17.8.101(27).

If the visual surveys are not performed once every two calendar weeks as specified above during the reporting period, then Graymont shall perform the Method 9 source tests on the sources for that reporting period.

Method 9 source tests must be performed in accordance with the Montana Source Test Protocol and Procedures Manual, except that prior notification of the test is not required. Each observation period must be a minimum of 6 minutes unless any one reading is 20% or greater, then the observation period must 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).

B.10. Graymont shall treat all unpaved portions of the haul roads, access roads, and the general plant area with water and/or chemical dust suppressant as necessary to maintain compliance with the reasonable precautions limitation in Section III.B.2 and Section III.B.3(ARM 17.8.749).

B.11. Graymont shall provide for water to be applied at material storage sites when it is necessary to meet the reasonable precautions requirement in Section III.B.2 and Section III.B.3 and for use in quarry drilling operations as specified in Section III.B.5(ARM 17.8.308(1) and ARM 17.8.749).

B.12. The compliance monitoring method for prevention of overshooting (Section III.B.4); fugitive dust control during drilling operations (Section III.B.5); minimization of materials fall distance (Section III.B.6 and Section III.B.7); and stabilization of disturbed or exposed areas (Section III.B.8) shall be accomplished through recordkeeping (ARM 17.8.1213).

B.13. Graymont shall utilize chemical dust suppressant, mulch, and/or re-vegetation practices as necessary for control of dust at exposed or disturbed areas (ARM 17.8.1213).

Recordkeeping

B.14. All 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. Method 9 source test reports for opacity need not be submitted unless requested by the Department. In addition, Graymont shall maintain a log to verify that the visual surveys were performed as specified in Section III.B.9. Each log entry must include the date, time, results of survey (and results of subsequent Method 9, if applicable), and observer's initials If any corrective action is required, the time, date, observer's initials, and any preventive or corrective action taken must be recorded in the log. If Method 9 tests are conducted to monitor compliance with Section III.B.1, the reports must be maintained on site and must be submitted to the Department upon request in accordance with the Montana Source Protocol and Procedures Manual. Whether visual surveys or Method 9 tests are conducted, 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 (ARM 17.8.1212).

B.15. Graymont shall maintain a quarry blasting operations log on site or under facility control. The log shall include the steps utilized to prepare for quarry blasting, all precautions taken to prevent overshooting, and the initials of the documenting personnel (ARM 17.8.1212).

B.16. Graymont shall maintain a log on site of any treatment done as required by Section III.B.10 and Section III.B.11. The log shall include the treatment method used and the initials of the documenting personnel (ARM 17.8.1212).

B.17. Graymont shall maintain records indicating the number of holes drilled, the number of blasts conducted, the type and tons of explosives used in blasting (ANFO), the acres of disturbed area and percent exposed, tons of limestone removed, tons of waste rock removed, the hours of operation of limestone and waste removal, vehicle miles traveled on haul roads and access roads, type of vehicle category, the percent of roads paved, application schedule for water or chemical dust suppressant, and gallons of diesel fuel used in vehicles.

In addition, Graymont shall maintain fugitive dust information consisting of a listing of all plant vehicles including vehicle type, vehicle weight, number of tires on vehicle, average trip length, number of trips per day, average vehicle speed, area of activity, and

the annual vehicle fuel usage (gasoline or diesel). If the information on vehicle size has not changed over the past year, Graymont need only supply the vehicle type and vehicle miles traveled by each vehicle type. If changes occur, Graymont shall supply the changed information as previously described (ARM 17.8.1212).

B.18. Graymont shall maintain an operations log documenting any fugitive dust control during drilling operations (Section III.B.5); minimization of material fall distance (Section III.B.6and Section III.B.7); and disturbed or exposed area stabilization activities (Section III.B.8) which deviate from normal operations as specified in Section III.B.5, Section III.B.6 Section III.B.7, and Section III.B.8. At a minimum, the log shall include the required information, the date, and the initials of the documenting personnel (ARM 17.8.1212).

Reporting

B.19. Production and fugitive dust information as specified in Section III.B.18 shall be gathered and submitted to the Department on an annual basis (ARM 17.8.1212).

B.20. 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.21. The annual compliance certification required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

B.22. The semiannual monitoring report shall provide (ARM 17.8.1212):

a. A summary of results of any source testing that was performed during that semiannual period;

b. A summary of corrective actions taken as a result of visual survey observations; and

c. A summary of any deviations reported with date of occurrence since the last report and a summary of any deviations not reported with date of occurrence since the last report.

C. ***EU006, EU007, EU008, EU009 - LIMESTONE PROCESSING OPERATIONS:***
Limestone Dumping and Primary Crushing, Limestone Screening, Raw Material Transfer and Stacker, and Limestone Dressing, Screening and Conveying;

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
C.1, C.6, C.10, C.13, C.14, C.15	Opacity	20%	Method 9 or	Semiannual	Semiannual
			Visual Surveys	Biweekly	
C.2, C.7, C.10, C.13, C.14, C.15	Opacity	Reasonable Precautions	Treatment	As Necessary	Semiannual
			Visual Surveys	Biweekly	
C.3, C.8, C.11, C.14, C.15	Particulate Matter	Enclosures and Baghouse	Operate and Maintain on Primary Crusher; Recordkeeping	Ongoing	Semiannual

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
C.4, C.9, C.10, C.14, C.15	Opacity	10%	Method 9	Initial and As Required by the Department and Section IIIA.1	Semiannual
C.5, C.11, C.12, C.14, C.15	Crushed Material	Fall Distance	Recordkeeping	Ongoing	Semiannual

Conditions

C.1. Graymont shall not cause or authorize to be discharged into the atmosphere from any source, visible emissions that exhibit an opacity of 20% or greater, unless specified elsewhere in this permit (ARM 17.8.304 and ARM 17.8.752).

C.2. Graymont 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 6 consecutive minutes unless otherwise specified by rule or in this permit (ARM 17.8.308(1)).

C.3. The primary crusher shall be enclosed and vented to a baghouse (ARM 17.8.749).

C.4. Graymont shall not cause or authorize to be discharged into the atmosphere from any screening operations, any transfer on a belt conveyor or any other affected equipment constructed, re-constructed, or modified after August 31, 1983, including, but not limited to the limestone Sugar Stone Screen and associated equipment, any fugitive emissions that exhibit greater than 10% opacity (ARM 17.8.752, ARM 17.8.340, 40 CFR 60 Subpart OOO).

C.5. Fall distance of crushed limestone to a storage pile shall be minimized (40 CFR 52.21).

Compliance Demonstration

C.6. Graymont shall either conduct a semiannual Method 9 source test or once every two calendar weeks, a visual survey of the visible emissions during quarry limestone processing including dumping, crushing, screening, and material transfer points. Visual surveys shall be performed on emissions from primary crusher loading/unloading, quarry limestone crushing and screening operations, all material transfer points associated with the primary crusher, and for any other associated source for visible emissions. Under the visual survey option, once every two calendar weeks, during daylight hours, Graymont shall visually survey the sources for any visible emissions. If visible emissions are observed during the visual survey, Graymont must conduct a Method 9 source test. The Method 9 source test must begin within one hour of any observation of visible emissions. If visible emissions meet or exceed 15% opacity based on the Method 9 source test, Graymont shall immediately take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Graymont shall immediately conduct a subsequent visual survey (and subsequent Method 9 source test if visible emissions remain) to monitor compliance. The person conducting the

visual survey shall record the results of the survey (including the results of any Method 9 source test performed) in a log, including any corrective action taken. Conducting a visual survey does not relieve Graymont of the liability for a violation determined using Method 9 (ARM 17.8.101(27)).

If the visual surveys are not performed once every two calendar weeks as specified above during the reporting period, then Graymont shall perform the Method 9 source tests on the sources for that reporting period.

Method 9 source tests must be performed in accordance with the Montana Source Test Protocol and Procedures Manual, except that prior notification of the test is not required.

Each observation period must be a minimum of 6 minutes unless any one reading is 20% or greater, then the observation period must 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.7. Graymont shall provide for water and/or chemical dust suppressant to be applied to sources of fugitive emissions when it is necessary to meet the reasonable precaution requirements of ARM 17.8.308 (1) as required in Section III.C.2(ARM 17.8.749).

C.8. The compliance monitoring method for the primary crusher baghouse control requirement (Section III.C.3) shall be accomplished through recordkeeping (ARM 17.8.1213).

C.9. The compliance monitoring method for crushed material fall distance (Section III.C.5) shall be accomplished through recordkeeping (ARM 17.8.1213).

Recordkeeping

C.10. All 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. Method 9 source test reports for opacity need not be submitted unless requested by the Department. In addition, Graymont shall maintain a log to verify that the visual surveys were performed as specified in Section III.C.6. Each log entry must include the date, time, results of survey (and results of subsequent Method 9, if applicable), and observer's initials If any corrective action is required, the time, date, observer's initials, and any preventive or corrective action taken must be recorded in the log. If Method 9 tests are conducted to monitor compliance with Section III.C.1the reports must be maintained on site and must be submitted to the Department upon request in accordance with the Montana Source Protocol and Procedures Manual. Whether visual surveys or Method 9 tests are conducted, 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 (ARM 17.8.1212).

C.11. Graymont shall maintain records indicating annual hours of primary crusher operation and total crusher production as tons of material through the primary crusher (ARM 17.8.1212).

C.12. Graymont shall maintain an operations log documenting any primary crusher control operations (Section III.C.3) and material fall distance activities (Section III.C.6) which deviate from normal operations as specified in Section III.C.3 and Section III.C.6. At a minimum, the log shall include the required information, the date, and the initials of the documenting personnel (ARM 17.8.1212).

Reporting

C.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).

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

C.15. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any source testing conducted during the period;

b. A summary of corrective actions taken as a result of visual survey observations; and

c. A summary of any deviations, including those described in Section III.C.11, reported with date of occurrence since the last report and a summary of any deviations not previously reported with date of occurrence since the last report.

D. ***EU011, EU012, EU013 - ROTARY LIME KILN OPERATIONS:***
Lime Kiln #1, Lime Kiln #2, and Kiln Dust Storage (baghouse and silo) and Handling

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
D.1, D.21, D.22, D.31,D.32 D.42	Particulate Matter	0.50 lb/ton of Limestone Feed	Method 5	Every 5 Years	Semiannual
			Inspection / Recordkeeping / CAM Plan, As Applicable Appendix E)	Ongoing	
D.2, D.23, D.33 D.34, D.40, D.42	Opacity	15%	COMS	Ongoing	Semiannual & Quarterly
D.3, D.24, D.33, D.42	Opacity	Reasonable Precautions 20%	Visual Survey	Biweekly	Semiannual
D.4, D.23, D.33, D.35, D.41, D.42	COMS	Ongoing Operation	Calibrate, Maintain, Operate	Ongoing	Semiannual & Quarterly
D.5, D.25, D.35, D.41, D.42	COMS	Inspection, Audit	Recordkeeping	Annually	Quarterly
D.6, D.29, D.40, D.42	Opacity	Implement Standard Operating Procedure Manuals and Quality Assurance Plans for COMS	Maintain	Ongoing	Semiannual

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
D.7, D.26, D.31, D.32, D.42	NO_x	100 lb/hr	Method 7, Method 7A-E	Every 2 Years	Semiannual
			Recordkeeping		
D.8, D.26, D.31, D.32, D.42	SO_2	63.5 lb/hr	Method 6, Method 6A-C	Every 2 Years	Semiannual
			Recordkeeping		
D.9, D.26, D.31, D.32, D.42	CO	131.0 lb/hr	Method 10, Method 10A-B	Every 2 Years	Semiannual
			Recordkeeping		
D.10, D.27, D.31, D.32, D.42	VOC	1.25 lb/hr	Method 18 and/or 25	As Required by the Department and Section IIIA.1	Semiannual
			Recordkeeping	Annual	
D.11, D.26, D.31, D.32, D.42	SO_2	ARM 17.8.322(6)(c)	Method 6, Method 6A-C	Every 2 Years	Semiannual
			Recordkeeping		
D.12, D.29, D.40, D.42	Exhaust Gas	Route to Twin Cyclone and Baghouse Control	Operate and maintain	Ongoing	Semiannual
D.13, D.28, D.36, D.42	Fuel Use	Coal, Syncoal, and Petroleum Coke	Recordkeeping	Ongoing	Semiannual
D.14 D.28, D.36, D.42	Petroleum Coke	No Burning Petroleum Coke Until Processing Limestone	Recordkeeping	Ongoing	Semiannual
D.15, D.29, D.40, D.42	Fugitive Emissions: Lime Kiln Dust Silo	Silo Enclosure (Wind Guards)	Install and Maintain	Ongoing	Semiannual
D.16, D.29, D.40, D.42	Fugitive Emissions: Lime Kiln Dust Unloading to Trucks	Telescopic Air Return System to	Operation and Maintenance	Ongoing	Semiannual

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
		Baghouse			
D.17, D.24, D.33, D.42	Opacity	Reasonable Precautions 20%	Visual Survey	Biweekly	Semiannual
D.18, D.29, D.40, D.42	Fugitive Emissions: Lime Kiln Dust Hauling	Covered	Operation and Maintenance	Ongoing	Semiannual
D.19, D.28, D.37, D.42	Speed Limit on 900-hp AC Motor for Lime Kiln #1 and Lime Kiln #2	1750 RPM	Recordkeeping	Ongoing	Semiannual
D.20, D.28, D.30, D.38, D.40, D.45	40 CFR 60, Subpart HH	40 CFR 60, Subpart HH	40 CFR 60, Subpart HH	40 CFR 60, Subpart HH	Semiannual

Conditions

D.1. Graymont shall not cause or authorize to be discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 any stack emissions that contain particulate matter in excess of 0.50 lb/ton of limestone feed (ARM 17.8.752).

D.2. Graymont shall not cause or authorize to be discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 any stack emissions that exhibit greater than 15% opacity (ARM 17.8.340, 40 CFR 60, Subpart HH).

D.3. Graymont 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 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.308(1)).

D.4. Graymont shall install, calibrate, maintain and operate a continuous opacity monitoring system (COMS) to monitor and record the opacity of a representative portion of the gases discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 (ARM 17.8.340 and 40 CFR 60, Subpart HH).

The continuous monitor shall be operated and maintained according to the following parameters and shall follow Graymont's Compliance Assurance Monitoring plan:

a. The span of these systems shall be set at 40% opacity.

b. The COMS shall conform to all requirements of 40 CFR, Part 60, Appendix Appendix B Performance Specification 1 – Specifications and Test Procedures for Opacity Continuous Emission Monitoring Systems in Stationary Sources (PS1).

c. The COMS data will be used to monitor compliance with the 15% opacity limitation in Section III.D.2. Graymont shall maintain, at a minimum, compliance with the 15% opacity limitation as monitored by the COMS, 95% of the time the COMS is operating.

d. When either COMS is not operating for a period of greater than 24 hours, Graymont shall monitor visible emissions from the lime kiln stack(s), which has a non-operational monitor(s), at least once per day using a certified visible emissions observer. The certified observer will perform visible emission observations and record the results. These observations will be conducted in accordance with 40 CFR Part 60, Appendix A, Method 9 and the Montana Visible Emissions Field Documentation Form. Further, these observations shall occur during normal operation of Lime Kiln #1 and Lime Kiln #2 and shall consist of three 6-minute averages. Finally, the lime production rate of the kiln observed shall be recorded.

e. Operation of the COMS on a kiln is not required if the corresponding kiln is not in operation.

D.5. Graymont shall inspect and audit the COMS annually using neutral density filters (ARM 17.8.749).

D.6. Graymont shall implement standard operating procedure manuals and quality assurance plans for the COMS (ARM 17.8.749).

D.7. Graymont shall not cause or authorize to be discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 any stack emissions which contain oxides of nitrogen emissions in excess of 100 lb/hr (ARM 17.8.819).

D.8. Graymont shall not cause or authorize to be discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 any stack emissions which contain sulfur dioxide emissions in excess of 63.5 lb/hr (ARM 17.8.819).

D.9. Graymont shall not cause or authorize to be discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 any stack emissions which contain carbon monoxide emissions in excess of 131 lb/hr (ARM 17.8.819).

D.10. Graymont shall not cause or authorize to be discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 any stack emissions which contain volatile organic compound emissions in excess of 1.25 lb/hr (ARM 17.8.752).

D.11. Graymont shall not cause or authorize to be discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 any stack emissions that do not comply with ARM 17.8.322(6)(c).

D.12. The exhaust gases from Lime Kiln #1 and Lime Kiln #2 shall be directed through twin cyclones in series with a baghouse (ARM 17.8.749 and 40 CFR 52.21).

D.13. Graymont is authorized to burn petroleum coke, coal, and/or syncoal in Lime Kiln #1 and Lime Kiln #2 (ARM 17.8.749).

D.14. Petroleum coke shall not be burned in either Lime Kiln #1 or Lime Kiln #2 until the kilns are processing limestone (ARM 17.8.749).

D.15. Graymont shall provide a partial enclosure (wind guards) on the Lime Kiln Dust Silos (ARM 17.8.749).

D.16. Graymont shall unload from the Lime Kiln Dust Silos to trucks using a telescopic system that has partial air return through an existing baghouse (ARM 17.8.749).

D.17. Graymont shall not cause or authorize to be discharged into the atmosphere visible emissions that exhibit an opacity of 20% or greater from the handling of Lime Kiln Baghouse dust (ARM 17.8.308).

D.18. All trucks hauling lime kiln dust shall be covered including all lime kiln dust transported off site for sale (ARM 17.8.749 and ARM 17.8.752).

D.19. The speed of the 900-hp AC motors on Lime Kiln #1 and Lime Kiln #2 shall be limited to a maximum of 1750 RPM per motor (ARM 17.8.749).

D.20. Graymont shall comply with all applicable standards and limitations, and the reporting, recordkeeping and notification requirements contained in 40 CFR 60, Subpart HH, as it applies to Lime Kiln #1 and Lime Kiln #2 (ARM 17.8.752, ARM 17.8.340, 40 CFR Part 60).

Compliance Demonstration

D.21. Graymont shall conduct Method 5 source testing for particulate matter emissions on both Lime Kiln #1 and Lime Kiln #2 and monitor compliance with Section III.D.1. The testing and compliance monitoring method shall occur on an every 5-year basis or another testing/monitoring schedule as may be approved by the Department. The test shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.105 and ARM 17.8.749). In addition, Graymont shall monitor baghouse performance for Lime Kiln #1 and #2 in accordance with Appendix E, Compliance Assurance Monitoring (CAM) (ARM 17.8.1213).

D.22. Graymont shall calibrate, maintain, and operate devices for measuring the mass rate of lime produced in Lime Kiln #1 and Lime Kiln #2. The measuring devices must be accurate to within ± 5% of the mass rate over its operating range.

This measuring device may be used in determining compliance with the condition in Section III.D.1 and 40 CFR 60.342. Operation of the device is only required during source testing monitoring compliance with applicable limits (ARM 17.8.749 and 40 CFR 52.21).

D.23. Graymont shall install, calibrate, maintain and operate a COMS to monitor and record the opacity of a representative portion of the gases discharged into the atmosphere from Lime Kiln #1 and Lime Kiln #2 (40 CFR 60, Subpart HH).

The COMS data will be used to monitor compliance with the 15% opacity limitation in Section III.D.2. Graymont shall maintain, at a minimum, compliance with the 15% opacity limitation as monitored by the COMS, 95% of the time the COMS is operating. Operations of the COMs shall follow Graymont's Compliance Assurance Monitoring plan.

When either COMS is not operating for a period of greater than 24 hours, Graymont shall monitor visible emissions from the lime kiln stack(s), which has a non-operational monitor(s), at least once per day using a certified visible emissions observer. The certified observer will perform visible emission observations and record the results. These observations will be conducted in accordance with 40 CFR Part 60, Appendix A, Method 9 and the Montana Visible Emissions Field Documentation Form. Further, these observations shall occur during normal operation of Lime Kiln #1 and Lime Kiln #2 and shall consist of three 6-minute averages. Finally, the lime production rate of the kiln observed shall be recorded. Graymont shall maintain a log indicating the date, time, reason, and the initials of the documenting personnel for all periods the COMS is not operating or not operating properly (ARM 17.8.1213).

D.24. Once every two calendar weeks, Graymont shall conduct a visual survey of the visible emissions from the handling of lime kiln baghouse dust. Once every two calendar weeks during daylight hours, Graymont shall visually survey the handling of lime kiln baghouse dust and for any other associated source for visible emissions. If visible emissions are observed during the visual survey, Graymont must conduct a Method 9 source test. The Method 9 source test must begin within one hour of any observation of visible emissions. If visible emissions meet or exceed 15% opacity based on the Method 9 source test, Graymont shall immediately take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Graymont shall immediately conduct a subsequent visual survey (and subsequent Method 9 source test if visible emissions remain) to monitor compliance. The person conducting the visual survey shall record the results of the survey (including the results of any Method 9 source test performed) in a log, including any corrective action taken. Conducting a visual survey does not relieve Graymont of the liability for a violation determined using Method 9 (ARM 17.8.101(27)).

Method 9 source tests must be performed in accordance with the Montana Source Test Protocol and Procedures Manual, except that prior notification of the test is not required. Each observation period must be a minimum of 6 minutes unless any one reading is 20% or greater, then the observation period must 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).

D.25. Graymont shall conduct the COMS audits, as required in Section III.D.5, using appropriate procedures and forms in the EPA Technical Assistance Document: Performance Audit Procedures for Opacity Monitors (EPA-450/4-92-010, April, 1992). The results of these inspections and audits shall be included in the quarterly excess emission report (ARM 17.8.1213).

D.26. Graymont shall conduct source testing on Lime Kiln #1 and Lime Kiln #2 for NO_x (Method 7, 7A-E), SO_2 (Method 6, 6A-C), and CO (Method 10, 10A-B), concurrently, and monitor compliance with the emission limitations contained in Section III.D.7, III.D.8, III.D.9, and III.D.11, respectively. Further testing and compliance monitoring for Lime Kiln #1 and Lime Kiln #2 shall occur on an every 2-year basis or another testing/monitoring schedule as may be approved by the Department. The test shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.105 and ARM 17.8.749).

For the 30-day period prior to submitting the pre-test protocol for the NO_x, SO_2, and CO source tests, described above, Graymont shall record the following parameters on an hourly basis. These hourly readings, along with the 30-day averages, shall be submitted with the pre-test protocol. The facility shall be operated in a manner consistent with these operating parameters during the source test. If both Lime Kiln #1 and Lime Kiln #2 are tested concurrently, data collected from either kiln will be sufficient.

a. Percent combustibles at kiln outlet

b. Percent oxygen at kiln outlet

c. Lime production rate

d. Coal combustion rate

e. Coke combustion rate

f. Pre-heater outlet temperature

g. Upper lime temperature

h. Hot zone temperature

i. Feed end temperature

Graymont shall also record the above parameters, on an hourly basis, during performance of the source test and submit this information as part of a complete source test report.

D.27. As required by the Department and Section III.A.1, Graymont shall conduct source testing on Lime Kiln #1 and Lime Kiln #2 for VOC emissions and monitor compliance with the emission limitation contained in Section III.D.10. The source test method used shall be Method 18 and/or Method 25 or another test method approved by the Department. The test shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.105 and ARM 17.8.749).

D.28. The compliance monitoring method for fuel use (Section III.D.13), petroleum coke burning only when processing limestone (Section III.D.14), the 1750 RPM limit for the 900-hp AC motors on Lime Kiln #1 and Lime Kiln #2 (Section III.D.19), and compliance with 40 CFR Part 60, Subpart HH, as applicable (Section III.D.20), shall be accomplished through recordkeeping. All records shall include the required information, the date, the time, and the initials of the documenting personnel (ARM 17.8.1213).

D.29. The compliance monitoring method for the COMS standard operating procedures (Section III.D.6); lime kiln exhaust gas routing (Section III.D.12); fugitive emissions from lime kiln dust silo (Section III.D.15); fugitive emissions control from lime kiln dust unloading to trucks (Section III.D.16); and fugitive emissions control from lime kiln dust hauling (Section III.D.18) shall be accomplished through recordkeeping (ARM 17.8.1213).

D.30. Graymont shall comply with all applicable standards and limitations, and the reporting, recordkeeping and notification requirements contained in 40 CFR 60, Subpart HH, as it applies to Lime Kiln #1 and Lime Kiln #2 (ARM 17.8.752, ARM 17.8.340, 40 CFR Part 60).

Recordkeeping

D.31. All 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. Method 9 source test reports for opacity need not be submitted unless requested by the Department. In addition, Graymont shall maintain a log to verify that the visual surveys were performed as specified in Section III.D.24. Each log entry must include the date, time, results of survey (and results of subsequent Method 9, if applicable), and observer's initials. If any corrective action is required, the time, date, observer's initials, and any preventive or corrective action taken must be recorded in the log. If Method 9 tests are conducted to monitor compliance with Section III.D.2, the reports must be maintained on site and must be submitted to the Department upon request in accordance with the Montana Source Protocol and Procedures Manual. Whether visual surveys or Method 9 tests are conducted, 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 (ARM 17.8.1212).

D.32. Graymont shall maintain production records indicating total amount of limestone processed in each lime kiln, the hours of operation of each lime kiln, tons of coal fired in each lime kiln, tons of syncoal fired in each lime kiln, tons of petroleum coke fired in each lime kiln, gallons of diesel fired in each lime kiln, and the tons of lime produced in each lime kiln (ARM 17.8.1212).

D.33. Graymont shall maintain on site a log containing any visual observations as required in Section III.D.4.d, III.D.23 and III.D.24. The log shall include the date, time, required data, and the initials of the documenting personnel. For Section III. D.24, each log entry must include the date, time, results of survey (and results of subsequent Method 9, if applicable), and observer's initials If any corrective action is required, the time, date, observer's initials, and any preventive or corrective action taken must be recorded in the log (ARM 17.8.1212).

D.34. Graymont shall maintain on site a log containing all evidence of excess emissions measured by the COMS, as required by Attachment 2 of Graymont's Montana Air Quality Permit. Periods of excess emissions shall be defined as those averaged over a 6-minute time period for which the average is greater than 15% opacity as required in section III.D.2 (ARM 17.8.1212).

D.35. Graymont shall maintain a file of all measurements from the COMS as required in Section III.D.4, the COMS inspection and audit requirement in Section III.D.5, and readings from the lime production monitor required in Section III.D.22. All COMS performance evaluations; all COMS or monitoring device calibration checks and audits; and all adjustments and maintenance performed on these systems or devices shall be recorded in a permanent form suitable for inspection. The file shall be retained on site for at least 5 years following the date of such measurements and reports. Graymont shall supply these records to the Department upon request (ARM 17.8.1212).

D.36. Graymont shall maintain a fuel log containing information on all coal, syncoal, and petroleum coke shipments to monitor compliance with the fuel use requirement in Section III.D.13. Further, the fuel log shall monitor compliance with the petroleum coke burning limitation in Section III.D.14 by documenting that petroleum coke was burned only when processing limestone. The log shall contain, at a minimum, the date, time, type of fuel, and the initials of the documenting personnel (ARM 17.8.1212).

D.37. Graymont shall maintain a daily operating log indicating compliance with the 1750 RPM limit on the 900-hp AC motors on Lime Kiln #1 and Lime Kiln #2 (Section III.D.19) (ARM 17.8.749).

D.38. Graymont shall comply with all applicable standards and limitations, and the reporting, recordkeeping and notification requirements contained in 40 CFR 60, Subpart HH, as it applies to Lime Kiln #1 and Lime Kiln #2 (ARM 17.8.752, ARM 17.8.340, 40 CFR Part 60).

D.39. Graymont shall maintain an operations log documenting any COM's standard operating procedures (Section III.D.6); lime kiln exhaust gas routing operations (Section III.D.12); fugitive emissions control operations from lime kiln dust silo (Section III.D.15); fugitive emissions control operations from lime kiln dust unloading to trucks (Section III.D.16); and fugitive emissions control operations from lime kiln dust hauling (Section III.D.18) which deviate from normal operations as specified in Section III.D.6, Section III.D.12, Section III.D.15, Section III.D.16, and Section III.D.18. At a minimum, the log shall include the required information, the date, and the initials of the documenting personnel (ARM 17.8.1212).

D.40. Graymont shall comply with all applicable standards and limitations, and the reporting, recordkeeping and notification requirements contained in 40 CFR 60, Subpart HH, as it applies to Lime Kiln #1 and Lime Kiln #2 (ARM 17.8.752, ARM 17.8.340, 40 CFR Part 60).

Reporting

D.41. 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.42. Graymont shall submit a written report of all excess emissions, as defined in Section III.D.34, quarterly. The report shall be in the format contained in Attachment 2 of Graymont's Montana Air Quality Permit and include, at a minimum, the following (ARM 17.8.1212):

a. The magnitude of excess emissions and the date and time of commencement and completion of each time period of excess emissions.

b. Specific identification of each period of excess emissions that occurs during start-ups, shutdowns, and malfunctions of the affected facility, the nature and cause of any malfunction (if known), and the corrective action taken or preventative measures adopted.

c. The date and time identifying each period during which the COMS was inoperative, except the zero and span checks. The nature of the system repairs or adjustments must also be reported.

d. When no excess emissions have occurred or the continuous monitoring system(s) have not been inoperative, repaired, or adjusted during a given reporting period, such information shall be stated in the report.

e. The percentage of time the COMS was operating calculated as:

1 – (hours of COMS downtime during reporting period/hours the source operated during the reporting period) x 100

This shall be reported as percent monitor availability during plant operation. Graymont shall maintain at least a minimum of 90% monitor availability during plant operation and shall meet the minimum frequency for operation required in 40 CFR Part 60.13(e).

f. The percentage of time the COMS indicated compliance calculated as:

1 – (total hours of excess emissions during the reporting period/total hours of COMS availability during the reporting period) x 100

This shall be reported as percent compliance. Graymont shall maintain, as a minimum, compliance with the 15% lime kiln opacity limitation, as monitored by the COMS, 95% of the time the COMS is operating.

g. The excess emissions report shall be submitted within 30 days following the end of the quarterly reporting period (January-March, April-June, July-September, and October-December).

h. The results of the inspections and audits required in Section III.D.5 shall be included in the quarterly excess emission report.

D.43. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

D.44. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of the results of any source testing conducted during the period;

b. A summary of the annual production information including the tons of limestone processed in Lime Kiln #1 and Lime Kiln #2;

c. A summary of any COMS downtime as required in Section III.D.4 and Section III.D.23;

d. A summary of corrective actions taken as a result of visual survey observations; and

e. A summary of any deviations reported with date of occurrence since the last report and a summary of any deviations not reported with date of occurrence since the last report.

f. Certification of compliance with the applicable CAM requirements as specified in Section III.D.21.

D.45. Graymont shall comply with all applicable standards and limitations, and the reporting, recordkeeping and notification requirements contained in 40 CFR 60, Subpart HH, as it applies to Lime Kiln #1 and Lime Kiln #2 (ARM 17.8.752, ARM 17.8.340, 40 CFR Part 60).

E. ***EU014, EU015, EU016, EU017 - LIME PRODUCT OPERATIONS:***
Crushing, Screening and Transfer, Lime Product Loadout, Railroad Lime Loadout, Railroad Unload.

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
E.1, E.7, E.10, E.11, E.13, E.14, E.15	Particulate Matter	0.0027 lb/ton Lime Product Shipped	Method 5	As Required by the Department and Section III.A.1	Semiannual
		Tons of Lime Product Produced /Shipped	Recordkeeping	Daily	
E.2, E.8, E.10,E.13, E.14, E.15	Opacity	20%	Method 9 or	Semiannual	Semiannual
			Visual Surveys	Biweekly	
E.3, E.10, E.14, E.15	Opacity	Reasonable Precautions	Visual Surveys	Biweekly	Semiannual
E.4, E.9, E.12,E.14, E.15	Fugitive Emissions: Finished Lime Product Storage and Handling	Enclosures and Baghouse	Recordkeeping	Ongoing	Semiannual
E.5, E.9, E.12, E.14, E.15	Fugitive Emissions: Finished Lime Product Conveyors	Enclosures	Recordkeeping	Ongoing	Semiannual
E.6, E.9, E.12, E.14, E.15	Fugitive Emissions: Lime Product Haul Trucks	Covered During Transport	Recordkeeping	Ongoing	Semiannual

Conditions

E.1. Particulate emissions from the lime baghouse (Micropul, Model 365-10-30) shall be limited to 0.0027 lb/ton of lime shipped (ARM 17.8.749).

E.2. Graymont shall not cause or authorize to be discharged into the atmosphere from any source at the facility, visible emissions that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless specified elsewhere in this permit (ARM 17.8.304 and 17.8.752).

E.3. Graymont 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 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.308(1)).

E.4. Emission points for the finished lime product crushing, storage, and load-out areas shall be enclosed and vented to a baghouse (ARM 17.8.749 and 40 CFR 52.21).

E.5. All conveyors that transport finished lime product shall be covered or enclosed (ARM 17.8.749).

E.6. Lime product haul trucks shall be covered during transport to the train load-out facility (ARM 17.8.749).

Compliance Demonstration

E.7. As required by the Department and Section III.A.1, Graymont shall conduct Method 5 source testing for particulate matter emissions on the lime baghouse and monitor compliance with Section III.E.1.The test shall be conducted in accordance with Montana Source Test Protocol and Procedures Manual. Further, Graymont shall record the total amount of lime product produced and shipped in tons of lime product (ARM 17.8.1213).

E.8. Graymont shall either conduct a semiannual Method 9 source test or once every two calendar weeks, a visual survey of the visible emissions from the lime processing operations. Under the visual survey option, once every two calendar weeks, during daylight hours, Graymont shall visually survey the sources for any visible emissions. If visible emissions are observed during the visual survey, Graymont must conduct a Method 9 source test. The Method 9 source test must begin within one hour of any observation of visible emissions. If visible emissions meet or exceed 15% opacity based on the Method 9 source test, Graymont shall immediately take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Graymont shall immediately conduct a subsequent visual survey (and subsequent Method 9 source test if visible emissions remain) to monitor compliance. The person conducting the visual survey shall record the results of the survey (including the results of any Method 9 source test performed) in a log, including any corrective action taken. Conducting a visual survey does not relieve Graymont of the liability for a violation determined using Method 9 (ARM 17.8.101(27)).

If the visual surveys are not performed once every two calendar weeks as specified above during the reporting period, then Graymont shall perform the Method 9 source tests on the sources for that reporting period.

Method 9 source tests must be performed in accordance with the Montana Source Test Protocol and Procedures Manual, except that prior notification of the test is not required. Each observation period must be a minimum of 6 minutes unless any one reading is 20% or greater, then the observation period must 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).

E.9. The compliance monitoring method for fugitive emissions control from finished lime product storage and handling (Section III.E.4); fugitive emissions control from finished lime product conveying (Section III.E.5); and fugitive emissions control from finished lime product haul trucks (Section III.E.6) shall be accomplished through recordkeeping (ARM 17.8.1213).

Recordkeeping

E.10. All 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. In addition, Graymont shall maintain a log to verify that the visual surveys were performed as specified in Section III.E.8. Each log entry must include the date, time, results of survey (and results of subsequent Method 9, if applicable), and observer's initials If any corrective action is required, the time, date, observer's initials, and any preventive or corrective action taken must be recorded in the log (ARM 17.8.1212).

E.11. While conducting a source test monitoring compliance with Section III.E.1, Graymont shall maintain a log indicating the total amount of lime product produced and shipped. The log shall include the date, time, required production information and the initials of the documenting personnel (ARM 17.8.1212).

E.12. Graymont shall maintain an operations log documenting any fugitive emission control for finished lime product storage and handling (Section III.E.4); fugitive emission control for finished lime product conveyors (Section III.E.5); and fugitive emission control for lime product haul trucks (Section III.E.6) which deviate from normal operations as specified in Section III.E.4, Section III.E.5, and Section III.E.6. At a minimum, the log shall include the required information, the date, and the initials of the documenting personnel (ARM 17.8.1212).

Reporting

E.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).

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

E.15. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of any source testing conducted during the time period;

b. A summary of corrective actions taken as a result of visual survey observations; and

c. A summary of any deviations reported with date of occurrence since the last report and a summary of any deviations not reported with date of occurrence since the last report.

F. ***EU018, EU019, EU020, EU021 - HYDRATED LIME PRODUCT OPERATIONS:***
Lime Hydrator Surge Bin; Lime Hydrator; Hydrated Lime Pulverizing, Storage and Transfer; and Hydrated Lime Loadout via Truck and Rail.

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
F.1, F.13, F.18, F.22, F.23	Particulate Matter	0.010 gr/acf	Method 5	As Required by the Department and Section III.A.1	Semiannual
F.2, F.13, F.18, F.22, F.23	Particulate Matter	0.020 gr/dscf	Method 5	As Required by the Department and Section III.A.1	Semiannual
F.3, F.14, F.18, F.22, F.23	Opacity	15%	Method 9	As Required by the Department and Section III.A.1	Semiannual
F.4, F.14, F.18, F.22, F.23	Opacity	Reasonable Precautions	Method 9	As Required by the Department and Section III.A.1	Semiannual
F.5, F.16, F.21, F.23	Particulate Matter Emission Control: Lime Hydrator	Fabric Filter Baghouse	Recordkeeping	Ongoing	Semiannual
F.5, F.17, F.20, F.23	Equipment Performance	Monitoring Devices	Calibrate Maintain and Operate	Ongoing	Annual
F.6, F.15, F.19 F.23	Production Limit	111,000 ton/yr Hydrated Lime	Recordkeeping	Monthly	Semiannual
F.7, F.16, F.21 F.23	Hydrated Lime Surge Bin Emission Control	Bin Vent Fabric Filter Control	Recordkeeping	Ongoing	Semiannual
F.8, F.16, F.21, F.23	Fugitive Emissions: Hydrated Lime Storage and Handling	Product Handling Dust Collector Control	Recordkeeping	Ongoing	Semiannual
F.9, F.16, F.21, F.23	Fugitive Emissions: Hydrated Lime Truck Load-Out	Fabric Filter Baghouse and Vacuum-Bot Loadout Spouts	Recordkeeping	Ongoing	Semiannual
F.10, F.16, F.21, F.24	Fugitive Emissions: Hydrated Lime Rail Loadout	Fabric Filter Baghouse and Vacuum-Boot Loadout Spouts	Recordkeeping	Ongoing	Semiannual

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
F.11, F.13, F.14 F.18, F.22, F.24	Particulate Matter Control: Hydrated Lime Truck Loadout	0.010 gr/acf	Method 5	As Required by the Department and Section III.A.1	Semiannual
		20%	Method 9		
F.12, F.13, F.14, F.18, F.22, F.24	Particulate Matter Control: Hydrated Lime Rail Loadout	0.010 gr/acf	Method 5	As Required by the Department and Section III.A.1	Semiannual
		20%	Method 9		

Conditions

F.1. Graymont shall not cause or authorize to be discharged into the atmosphere from the lime hydrator, any emissions that contain filterable particulate matter in excess of 0.01 grains per actual cubic foot (gr/acfm) of exhaust flow (ARM 17.8.752).

F.2. Graymont shall not cause or authorize to be discharged into the atmosphere from the lime handling bin vent (controlling the surge bin (N401)); the hydrated lime product handling dust collector (controlling the bucket conveyor, roller mill,, and product recovery cyclone); any emissions that contain particulate matter in excess of 0.020 gr/dscf (ARM 17.8.752).

F.3. Graymont shall not cause or authorize to be discharged into the atmosphere from the lime hydrator; the lime handling bin vent (controlling the surge bin (N401)); the hydrated lime product handling dust collector (controlling the bucket conveyor, roller mill, and product recovery cyclone) any visible emissions that exhibit an opacity of 15% or greater averaged over 6 consecutive minutes, unless specified elsewhere in this permit (ARM 17.8.752).

F.4. Graymont 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 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.308(1)).

F.5. The lime hydrator shall be vented through a fabric filter baghouse (ARM 17.8.752).

a. Graymont shall install, calibrate, maintain and operate monitoring a device to measurement of the following pressure drop across the baghouse (ARM 17.8.749).

b. Graymont shall record measurements from the devices listed in Section III.5.a and during the performance of all compliance tests and at least once per shift while the system is in operation.

F.6. The lime hydrator shall be limited to a maximum production of 111,000 tons of lime hydrate produced during any rolling 12-month time period (ARM 17.8.749).

F.7. The hydrator surge bin emissions shall be controlled by a bin vent fabric filter (ARM 17.8.749).

F.8. The bucket conveyor emissions, roller mill, and hydrate product recovery cyclone shall be controlled by the hydrated lime product handling dust collector (ARM 17.8.749).

F.9. The hydrated lime truck loadout and hydrated lime truck loadout storage silo shall be controlled by a fabric filter baghouse and utilize extendable vacuum-boot loadout spouts (ARM 17.8.752).

F.10. The hydrated lime railcar loadout and hydrated lime railcar loadout storage silo shall be controlled by a fabric filter baghouse and utilize extendable vacuum-boot loadout spouts (ARM 17.8.752).

F.11. Graymont shall not cause or authorize to be discharged into the atmosphere from the hydrated lime truck loadout and storage silo fabric filter baghouse any emissions that:

a. Contain filterable particulate matter in excess of 0.010 gr/dscf of exhaust flow (ARM 17.8.752)

b. Exhibit greater than 20% opacity (ARM 17.8.752)

F.12. Graymont shall not cause or authorize to be discharged in to the atmosphere form the hydrated lime railcar loadout and storage silo fabric filter baghouse any emissions that:

a. Contain filterable particulate matter in excess of 0.010 gr/dscf of exhaust flow (ARM 17.8.752).

b. Exhibit greater than 20% opacity (ARM 17.8.752).

Compliance Demonstration

F.13. As required by the Department and Section III.A.1, Graymont shall conduct Method 5 source testing for particulate matter emissions on the lime hydrator; the lime handling bin vent (controlling the surge bin (N401)); the hydrated lime product handling dust collector (controlling the bucket conveyor, roller mill, and product recovery cyclone); the hydrated lime truck loadout baghouse; and and the hydrated lime rail loadout baghouse and monitor compliance with Sections III.F.1, III.F.2, III.F.11.a and Section III. F.12.a, respectively. The source testing shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.105 and ARM 17.8.749).

F.14. As required by the Department and Section III.A.1, Graymont shall perform a Method 9 test in accordance with Montana Source Test Protocol and Procedures Manual and monitor compliance with Sections III.F.3 III.F.4, III.F.11.b, and III.F.12.b(ARM 17.8.106). Each observation period shall be minimum of 6 minutes unless any one reading is 15% or greater (Section III.F.3) or 20% or greater (Sections III.F.4, III.F.11.b, and III.F.12.b), as applicable; 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).

F.15. The compliance monitoring method for the lime hydrator production limit (Section III.F.6) shall be accomplished through recordkeeping. All records shall include the required information, the date, the time, and the initials of the documenting personnel (ARM 17.8.1213).

F.16. The compliance monitoring method for particulate matter emission control for the lime hydrator (Section III.F.5); hydrator surge bin emission control (Section III.F.7); fugitive emissions control from hydrated lime storage and handling practices (Section III.F.8); and fugitive emissions control from hydrated lime truck loadout practices (Section III.F.9); and fugitive emissions control from hydrated lime rail loadout practices (Section III.F.10) shall be accomplished through recordkeeping (ARM 17.8.1213).

F.17. The compliance monitoring method for equipment performance shall be accomplished through recordkeeping (Section III.F.5.b) (ARM 17.8.1213).

Recordkeeping

F.18. All 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 17.8.1212).

F.19. Graymont shall document, by month, the lime hydrator production , in tons. By the 25th day of each month, Graymont shall total the hydrated lime produced during the previous 12 months to verify compliance with the limitation in Section III.F.6. A written report of the compliance verification shall be submitted to the Department annually. The report for the previous calendar year shall be submitted no later than March 15 and may be submitted along with the annual emission inventory (ARM 17.8.749).

F.20. Graymont shall maintain a record of all monitoring requirements as outlined in Section III.F.5.b(ARM 17.8.1212).

F.21. Graymont shall maintain an operations log documenting any lime hydrator particulate matter emission control (Section III.F.5); hydrator surge bin emission control (Section III.F.7); fugitive emissions control from hydrated lime storage and handling (Section III.F.8); fugitive emissions control from hydrated lime truck loadout (Section III.F.9); and fugitive emissions control form hydrated lime rail loadout (Section III.F.10) which deviate from normal operations as specified in Section III.F.5, Section III.F.6, Section III.F.7, Section III.F.8, and Section III.F.9. At a minimum, the log shall include the required information, the date, and the initials of the documenting personnel (ARM 17.8.1212).

Reporting

F.22. 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.23. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements (ARM 17.8.1212).

F.24. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of the any source testing that was performed during the period;

b. A summary of any deviations reported with date of occurrence since the last report and a summary of any deviations not reported with date of occurrence since the last report; and

c. A summary of the production and operating limits as specified in Section III.F.19.

G. *EU022, EU023, EU024 - COAL, SYNCOAL, AND PETROLEUM COKE STORAGE, HANDLING, AND PROCESSING OPERATIONS:*
Coal Unloading, Handling, and Storage; Coal, Syncoal, and Petroleum Coke Handling and Blending; and Coal, Syncoal, and Petroleum Coke Crushing and Handling.

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
G.1, G.9, G.12, G.13, G.14, G.17, G.18, G.19	Particulate Matter	0.0001 lb/ton Coal Fired	Method 5	As Required by the Department and Section III.A.1	Semiannual
			Recordkeeping	Daily During Source Testing	
G.2, G.3, G.10, G.13, G.17, G.18, G.19	Opacity	20% and Reasonable Precautions	Method 9 or	Semiannual	Semiannual
			Visual Survey	Biweekly	
G.4, G.11, G.15, G.18 G.19	Fugitive Emissions: Coal/Coke Dump	Partial Enclosure, Shelter	Recordkeeping	Ongoing	Semiannual
G.5, G.11, G.15, G.18, G.19	Fugitive Emissions: Coal Bins	Enclosure and Baghouse	Recordkeeping	Ongoing	Semiannual
G.6, G.11, G.15, G.18, G.19	Fugitive Emissions: Coal Conveyor (C -291)	Cover	Recordkeeping	Ongoing	Semiannual
G.7, G.11, G.15, G.18. G.19	Fugitive Emissions: Coal Haul Trucks	Cover	Recordkeeping	Ongoing	Semiannual
G.8, G.16, G.18 G.19	NSPS Requirements 40 CFR Part 60 Subpart Y	Applicable Requirements	Recordkeeping	As Necessary	Semiannual

Conditions

G.1. Graymont shall not cause or authorize to be discharged into the atmosphere from the coal baghouse (Micropul, Model 8-B, 400 acfm), emissions that contain particulate matter in excess of 0.0001 lb/ton coal fired (ARM 17.8.749).

G.2. Graymont shall not cause or authorize to be discharged into the atmosphere from any 40 CFR Part 60, Subpart Y affected source, visible emissions that exhibit an opacity of 20% or greater, unless specified elsewhere in this permit (ARM 17.8.304, ARM 17.8.752, and 40 CFR 60, Subpart Y).

G.3. Graymont 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 6 consecutive minutes, unless otherwise specified by rule or in this permit (ARM 17.8.308(1)).

G.4. The coal/coke dump shall be sheltered as necessary to maintain compliance with the 20% opacity limitation (ARM 17.8.308 and 40 CFR 52.21).

G.5. The coal bins shall be totally enclosed and vented to a baghouse (ARM 17.8.749 and 40 CFR 52.21).

G.6. The Coal Conveyor (C-291) between the silo and the coal mill shall be covered (ARM 17.8.749).

G.7. Trucks hauling coal from the train loadout to the plant shall be covered (ARM 17.8.749).

G.8. Graymont shall comply with all applicable standards and limitations, and the reporting, recordkeeping, and notification requirements contained in 40 CFR Part 60, Subpart Y (ARM 17.8.752, ARM 17.8.340, 40 CFR 60).

Compliance Demonstration

G.9. As required by the Department and Section III.A.1, Graymont shall conduct Method 5 source testing for particulate matter emissions from the coal baghouse (Micropul, Model 8-B, 400 acfm) and monitor compliance with Section III.G.1. The test shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual. The sampling time and sampling volume shall be at least 60 minutes and 0.85 dscm (30 dscf), respectively. Sampling shall begin no less than 30 minutes after start-up and shall terminate before shutdown procedures begin (ARM 17.8.105, ARM 17.8.749, and 40 CFR 60, Subpart Y).

G.10. Graymont shall either conduct a semiannual Method 9 source test or once every two calendar weeks, a visual survey of the visible emissions from the coal, syncoal, and petroleum coke storage, handling, and processing operations. Under the visual survey option, once every two calendar weeks, during daylight hours, Graymont shall visually survey the sources for any visible emissions. If visible emissions are observed during the visual survey, Graymont must conduct a Method 9 source test. The Method 9 source test must begin within one hour of any observation of visible emissions. If visible emissions meet or exceed 15% opacity based on the Method 9 source test, Graymont shall immediately take corrective action to contain or minimize the source of emissions. If corrective actions are taken, then Graymont shall immediately conduct a subsequent visual survey (and subsequent Method 9 source test if visible emissions remain) to monitor compliance. The person conducting the visual survey shall record the results of the survey (including the results of any Method 9 source test performed) in a log, including any corrective action taken. Conducting a visual survey does not relieve Graymont of the liability for a violation determined using Method 9 (ARM 17.8.101(27)).

If the visual surveys are not performed once every two calendar weeks as specified above during the reporting period, then Graymont shall perform the Method 9 source tests on the sources for that reporting period.

Method 9 source tests must be performed in accordance with the Montana Source Test Protocol and Procedures Manual, except that prior notification of the test is not required. Each observation period must be a minimum of 6 minutes unless any one reading is 20% or greater, then the observation period must 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).

G.11. The compliance monitoring method for the coal/coke dump shelter (Section III.G.4); the control of fugitive emissions from coal bins (Section III.G.5); the control of fugitive emissions from the coal conveyor C-291 (Section III.G.6); and the control of fugitive emissions from coal haul trucks (Section III.G.7) shall be accomplished through recordkeeping (ARM 17.8.1213).

G.12. Graymont shall comply with 40 CFR 60, Subpart Y, as applicable (ARM 17.8.1213).

Recordkeeping

G.13. All 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. In addition, Graymont shall maintain a log to verify that the visual surveys were performed as specified in Section III.G.10. Each log entry must include the date, time, results of survey (and results of subsequent Method 9, if applicable), and observer's initials. If any corrective action is required, the time, date, observer's initials, and any preventive or corrective action taken must be recorded in the log. If Method 9 tests are conducted to monitor compliance with Section III.G.2 and Section III.G.3, the reports must be maintained on site and must be submitted to the Department, upon request, in accordance with the Montana Source Test Protocol and Procedures Manual. (ARM 17.8.1212).

G.14. While conducting a source test monitoring compliance with Section III.G.1, Graymont shall maintain daily records indicating total tons of coal unloaded at the facility (ARM 17.8.1212).

G.15. Graymont shall maintain an operations log documenting any coal/coke dump sheltering activities (Section III.G.4); fugitive emission control for coal bins (Section III.G.5), fugitive emission control for coal conveyor C-291 (Section III.G.6), and fugitive emission control for coal haul trucks (Section III.G.7) which deviate from normal operations as specified in Section III.G.5, Section III.G.6, and Section III.G.7. At a minimum, the log shall include the required information, the date, and the initials of the documenting personnel (ARM 17.8.1212).

G.16. Graymont shall perform recordkeeping in accordance with 40 CFR Part 60, Subpart Y, as applicable (ARM 17.8.1212).

Reporting

G.17. 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.18. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements.

G.19. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of any source testing that was performed during the period;

b. A summary of corrective actions taken as a result of visual survey observations; and

c. A summary of any deviations reported with date of occurrence since the last report and a summary of any deviations not reported with date of occurrence since the last report.

H. *EU025, EU026 – DIESEL FUEL USE, GASOLINE FUEL USE.*

Condition(s)	Pollutant/Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
H.1, H.4, H.7, H.9, H.10	Particulate Matter	$E = 1.026 * H^{-0.233}$	Method 5	As Required by the Department and Section III.A.1	Semiannual
H.2, H.5 H.7, H.9 H.10	Opacity	20%	Method 9	As Required by the Department and Section III.A.1	Semiannual
H.3 H.6 H.8, H.11. H.12	Hazardous Air Pollutants (HAPs)	40 CFR 63, Subpart ZZZZ	40 CFR 63, Subpart ZZZZ	40 CFR 63, Subpart ZZZZ	40 CFR 63, Subpart ZZZZ

Conditions

H.1. Unless otherwise specified by rule or in this permit, Graymont 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 (ARM 17.8.309):

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

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

H.2. Graymont shall not cause or authorize to be discharged into the atmosphere from any source, visible emissions that exhibit an opacity of 20% or greater, unless specified elsewhere in this permit (ARM 17.8.304, ARM 17.8.752).

H.3. Graymont shall apply with all applicable requirements of 40 CFR 63 Subpart ZZZZ – NESHAPS: Stationary Reciprocating Internal Combustion Engines (ARM 17.8.342 and 40 CFR 63, Subpart ZZZZ).

Compliance Demonstration

H.4. As required by the Department and Section III.A.1Graymont shall conduct Method 5 source testing for particulate matter emissions from the burning of diesel and gasoline fuels in various sources, including, but not limited to the rotary lime kilns (EU010 and EU011) during start-up operations. The tests shall be conducted in accordance with the Montana Source Test Protocol and Procedures Manual (ARM 17.8.105 and ARM 17.8.749).

H.5. As required by the Department and Section III.A.1, Graymont shall perform a Method 9 test in accordance with Montana Source Test Protocol and Procedures Manual and monitor compliance with Section III.H.2 (ARM 17.8.106). Each observation period shall be minimum of 6 minutes unless any one reading is 20% or greater; 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.

H.6. Graymont shall meet the applicable requirements of all testing and procedures of ARM 17.8.342 which references 40 CFR 63, Subpart ZZZZ - Stationary Reciprocating Internal Combustion Engines (ARM 17.8.342 and 40 CFR 63, Subpart ZZZZ).

Recordkeeping

H.7. All 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. Method 9 source test reports for opacity need not be submitted unless requested by the Department (ARM 17.8.1212).

H.8. Graymont shall meet the applicable recordkeeping requirements as required by 40 CFR 63, Subpart ZZZZ- Stationary Reciprocating Internal Combustion Engines (ARM 17.8.342 and 40 CFR 63 Subpart ZZZZ).

Reporting

H.9. 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.10. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements.

H.11. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of any source testing that was performed during the period and

b. A summary of any deviations reported with date of occurrence since the last report and a summary of any deviations not reported with date of occurrence since the last report.

H.12. Graymont shall meet the applicable reporting requirements as required by40 CFR 63 Subpart ZZZZ- Stationary Reciprocating Internal Combustion Engines (ARM 17.8.342 and 40 CFR 63 Subpart ZZZZ).

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 Quality Bureau of the Department of Environmental Quality.

Rule Citation	Reason
40 CFR 57, 40 CFR 60 Subpart B, 40 CFR 60 Subpart C, Ca, Cb, Cc, Cd and Ce, 40 CFR 60 Subpart D, Da, Db, and Dc, 40 CFR 60 Subpart E, Ea, Eb and Ec, 40 CFR 60 Subpart F through Subpart X, 40 CFR 60 Subpart Z 40 CFR 60 Subpart AA through Subpart EE, 40 CFR 60 Subpart GG through Subpart HH, 40 CFR 60 Subpart KK through Subpart NN, 40 CFR 60 Subpart PP through Subpart XX, 40 CFR 60 Subpart AAA and Subpart BBB 40 CFR 60 Subpart DDD 40 CFR 60 Subpart FFF through Subpart LLL, 40 CFR 60 Subpart NNN 40 CFR 60 Subpart PPP through Subpart WWW. 40 CFR 60 Subpart AAAA through FFFF 40 CFR 60 Subpart HHHH through MMMM 40 CFR 61 Subpart B through Subpart F, 40 CFR 61 Subpart H through Subpart R, 40 CFR 61 Subpart T, 40 CFR 61 Subpart V and Subpart W, 40 CFR 61 Subpart Y 40 CFR 61 Subpart BB, 40 CFR 61 Subpart FF. 40 CFR 63 Subpart F through Subpart J, 40 CFR 63 Subpart L through Subpart O, 40 CFR 63 Subpart Q through Subpart U, 40 CFR 63 Subpart W through Subpart Y 40 CFR 63 Subpart AA through Subpart EE, 40 CFR 63 Subpart GG through Subpart MM 40 CFR 63 Subpart OO through Subpart YY, 40 CFR 63 Subpart CCC through FFF, 40 CFR 63 Subpart GGG through JJJ, 40 CFR 63 Subpart LLL through RRR, 40 CFR 63 Subpart TTT through VVV, 40 CFR 63 Subpart XXX 40 CFR 63 Subpart AAAA 40 CFR 63 Subpart CCCC through KKKK	These rules are not applicable because the facility is not listed in the source category cited in the rules.

Rule Citation	Reason
40 CFR 63 Subpart MMMM through YYYY 40 CFR 63 Subpart BBBBB through NNNNN 40 CFR 63 Subpart PPPPP through TTTTT 40 CFR 63 Subpart WWWWW 40 CFR 63 Subpart YYYYY 40 CFR 63 Subpart ZZZZZ 40 CFR 63 Subpart BBBBBB 40 CFR 63 Subpart DDDDDD through HHHHHH 40 CFR 63 Subpart LLLLLL through TTTTTT 40 CFR 63 Subpart VVVVVV through ZZZZZZ 40 CFR 63 Subpart AAAAAAA through EEEEEEE ARM 17.8.321, ARM 17.8.323, ARM 17.8.330 through 17.8.334, ARM 17.8.610	
ARM 17.8.316, ARM 17.8.320	These rules are not applicable because the facility does not have the specific emissions unit cited in the rules.
40 CFR 55	This regulation contains requirements to control air pollution from outer continental shelf sources, and does not contain requirements specifically relevant to this facility.
ARM 17.8.402	This rule does not apply because no changes have been made at the facility that would trigger these procedural requirements.

B. Emission Units

The permit renewal 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 & O).

D. ***Monitoring, Recordkeeping, and Reporting Requirements***
ARM 17.8, Subchapter 12, Operating Permit Program §1212(2)&(3)

1. Unless otherwise provided in this permit, the permittee shall maintain compliance monitoring records that include the following information:

   a. The date, place as defined in the permit, and time of sampling or measurement;

   b. The date(s) analyses were performed;

   c. The company or entity that performed the analyses;

   d. The analytical techniques or methods used;

   e. The results of such analyses; and

f. The operating conditions at the time of sampling or measurement.

2. The permittee shall retain records of all required monitoring data and support information for a period of at least 5 years from the date of the monitoring sample, measurement, report, or application. Support information includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by the permit. All monitoring data, support information, and required reports and summaries may be maintained in computerized form at the plant site if the information is made available to Department personnel upon request, which may be for either hard copies or computerized format. Strip-charts must be maintained in their original form at the plant site and shall be made available to Department personnel upon request.

3. The permittee shall submit to the Department, at the addresses located in the Notification Addresses Appendix of this permit, reports of any required monitoring by 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)(b)

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 to the Department within the following timeframes (unless otherwise specified in an applicable requirement):

1. For deviations which may result in emissions potentially in violation of permit limitations:

   a. An initial phone notification (or faxed or electronic notification) describing the incident within 24 hours (or the next business day) of discovery; and,

   b. A follow-up written, faxed, or electronic report within 30 days of discovery of the deviation that describes the probable cause of the reported deviation and any corrective actions or preventative measures taken.

2. For deviations attributable to malfunctions, deviations shall be reported to the Department in accordance with the malfunction reporting requirements under ARM 17.8.110; and

3. For all other deviations, deviations shall be reported to the Department via a written, faxed, or electronic report within 90 days of discovery (as determined through routine internal review by the permittee).

Prompt deviation reports do not need to be resubmitted with regular semiannual (or other routine) reports, but may be referenced by the date of submittal.

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 2 working days of the time when emission limitations were exceeded due to the emergency. This notice fulfills the requirements of ARM 17.8.1212(3)(b). 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 a Montana Air Quality 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 7 days prior to making the proposed changes.

2. The permittee and the Department shall attach each notice provided pursuant to 1.e above to their respective copies of this permit.

3. Pursuant to the conditions above, the permittee is authorized to make Section 502(b)(10) changes, as defined in ARM 17.8.1201(30), without a permit revision. For each such change, the written notification required under 1.e above shall include a description of the change within the source, the date on which the change will occur, any change in emissions, and any permit term or condition that is no longer applicable as a result of the change.

4. The permittee may make a change not specifically addressed or prohibited by the permit terms and conditions without requiring a permit revision, provided the following conditions are met:

   a. Each proposed change does not weaken the enforceability of any existing permit conditions;

   b. The Department has not objected to such change;

   c. Each proposed change meets all applicable requirements and does not violate any existing permit term or condition; 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 3 or more years. Reopening and revision of the permit shall be completed not later than 18 months after promulgation of the applicable requirement. No reopening is required under ARM 17.8.1228(1)(a) if the effective date of the applicable requirement is later than the date on which the permit is due to expire, unless the original permit or any of its terms or conditions have been extended pursuant to ARM 17.8.1220(12) or 17.8.1221(2);

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 5 years.

2. Renewal of this permit is subject to the same procedural requirements that apply to permit issuance, including those for application, content, public participation, and affected state and administrator review.

3. Expiration of this permit terminates the permittee's right to operate unless a timely and administratively complete renewal application has been submitted consistent with ARM 17.8.1221 and 17.8.1205(2)(d). If a timely and administratively complete application has been submitted, all terms and conditions of the permit, including the application shield, remain in effect after the permit expires until the permit renewal has been issued or denied.

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

N. ***Severability Clause***

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

1. The administrative appeal or subsequent judicial review of the issuance by the Department of an initial permit under this subchapter shall not impair in any manner the underlying applicability of all applicable requirements, and such requirements continue to apply as if a final permit decision had not been reached by the Department.

2. If any provision of a permit is found to be invalid, all valid parts that are severable from the invalid part remain in effect. If a provision of a permit is invalid in one or more of its applications, the provision remains in effect in all valid applications that are severable from the invalid applications.

O. ***Transfer or Assignment of Ownership***

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

1. If an administrative permit amendment involves a change in ownership or operational control, the applicant must include in its request to the Department a written agreement containing a specific date for the transfer of permit responsibility, coverage and liability between the current and new permittee.

2. The permit shield provided for in ARM17.8.1214 shall not extend to administrative permit amendments.

P. *Emissions Trading, Marketable Permits, Economic Incentives*
ARM 17.8, Subchapter 12, Operating Permit Program §1226(2)

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

Q. *No Property Rights Conveyed*
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(d)

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

R. *Testing Requirements*
ARM 17.8, Subchapter 1, General Provisions §105

The permittee shall comply with ARM 17.8.105.

S. *Source Testing Protocol*
ARM 17.8, Subchapter 1, General Provisions §106

The permittee shall comply with ARM 17.8.106.

T. *Malfunctions*
ARM 17.8, Subchapter 1, General Provisions §110

The permittee shall comply with ARM 17.8.110.

U. *Circumvention*
ARM 17.8, Subchapter 1, General Provisions §111

The permittee shall comply with ARM 17.8.111.

V. *Motor Vehicles*
ARM 17.8, Subchapter 3, Emission Standards §325

The permittee shall comply with ARM 17.8.325.

W. *Annual Emissions Inventory*
ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation and Open Burning Fees §505 (STATE ONLY)

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

X. *Open Burning*

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

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

Y. *Montana Air Quality Permits*

ARM 17.8, Subchapter 7, Permit, Construction and Operation of Air Contaminant Sources §745 and 764

1. Except as specified, no person shall construct, install, modify 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 a Montana Air Quality Permit (MAQP) issued under Chapter 8 that does not increase the facility's potential to emit by more than 5 tons per year of any pollutant, except:

    a. Any construction or changed condition that would violate any condition in the facility's existing MAQP 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 5 tons per year may not be artificially split into smaller projects to avoid Montana Air Quality 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).

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 Graymont, 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 Section 7412 (b) of the FCAA; and (iv) is not regulated by an applicable requirement, other than a generally applicable requirement that applies to all emission units subject to Subchapter 12.

List of Insignificant Activities:
The following table of insignificant sources and/or activities were provided by Graymont.

Emissions Unit ID	Description
IEU001	Limestone Removal / Loading
IEU002	Waste (fines) Removal and Loading
IEU003	Removal to Dressing Screen Stockpile
IEU004	Fuel Storage Tanks
IEU005	Diesel Garage Heaters
IEU006	Core Bin/Bunker Loadout
IEU007	Portable Coal Conveyor System

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 Graymont;

(d) requires changes in monitoring or reporting requirements that the Department deems to be no less stringent than current monitoring or reporting requirements;

(e) allows for a change in ownership or operational control of a source if the Department has determined that no other change in the air quality operating permit is necessary, consistent with ARM 17.8.1225; or

(f) incorporates any other type of change which the Department has determined to be similar to those revisions set forth in (a)-(e), above.

"Applicable requirement" means all of the following as they apply to 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 Montana Air Quality 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 Section 7411 of the FCAA, including Section 7411(d);

(d) any standard or other requirement under Section 7412 of the FCAA, including any requirement concerning accident prevention under Section 7412(r)(7), but excluding the contents of any risk management plan required under Section 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 Section 7661c(b) or Section 7414(a)(3) of the FCAA;

(g) any standard or other requirement governing solid waste incineration, under Section 7429 of the FCAA;

(h) any standard or other requirement for consumer and commercial products, under Section 7511b(e) of the FCAA;

(i) any standard or other requirement for tank vessels, under Section 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 Section 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.

"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 Section 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 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 which could not reasonably pass through a stack, chimney, vent, or other functionally equivalent opening.

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

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

"Non-federally enforceable requirement" means the following as they apply to 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 Montana Air Quality 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 Section 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 Section 7412 of the FCAA, including but not limited to the following:

(i) any pollutant subject to requirements under Section 7412(j) of the FCAA. If the administrator fails to promulgate a standard by the date established in Section 7412(e) of the FCAA, any pollutant for which a subject source would be major shall be considered to be regulated on the date 18 months after the applicable date established in Section 7412(e) of the FCAA;

(ii) any pollutant for which the requirements of Section 7412(g)(2) of the FCAA have been met but only with respect to the individual source subject to Section 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
scf	standard cubic feet
SIC	Source Industrial Classification
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
Air, Energy, and Mining Division
Air Quality 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
Air, Energy, and Mining Division
Air Quality 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
1595 Wynkoop Street
Denver, CO 80202-1129

Appendix D AIR QUALITY INSPECTOR INFORMATION

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

1. **Direction to Plant:** A map is on file with the Department.

   The plant is located approximately 4.5 miles west of Townsend, Montana, on Indian Creek Road. Indian Creek Road is located approximately 1 mile north of Townsend, Montana, off Montana Highway 12. Head west off Montana Highway 12 on Indian creek road for approximately 4.5 miles. Indian Creek Road has numerous signs documenting directions to the Graymont facility.

2. **Safety Equipment Required:** The following safety equipment is required:

   Hard Hat
   Safety Glasses
   Steel Toed Boots

3. **Facility Plot Plan:** A facility plot plan is on file with the Department.

Appendix E COMPLIANCE ASSURANCE MONITORING PLAN

I. Emitting Unit: Rotary Lime Kiln #1
Pollutant: Particulate Matter (PM)
Control Device: Negative Pressure Pulsed Jet Fabric Filter Baghouse
Emission Limit: 0.50 pounds per ton (lb/ton) of limestone feed
Monitoring Approach: Key elements of the monitoring approach for this Compliance Assurance Monitoring (CAM) applicable pollutant specific emitting unit (PSEU) are contained in Table I. A complete CAM plan is contained in the Graymont Western US, Inc., application for Title V operating permit renewal (#OP1554-04) and is on file with the Department. Complete copies of this CAM plan are available from the Department upon request.

CAM PLAN: TABLE I	
A. General Criteria	**Indicator**
1. Indicator	Opacity
2. Monitoring Approach	Opacity is measured and recorded continuously with a continuous opacity monitoring system (COMS)
3. Indicator Range	The indicator level is an opacity reading equal to or exceeding 12%. An excursion will be defined as any 24-hour period in which all 6-minute average opacity readings exceed 12% opacity. Opacity readings exceeding 12% opacity during periods of kiln start-up are not included in the 24-hour period evaluation.
4. Quality Improvement Plan (QIP) Threshold	The QIP threshold is excursions occurring greater than 5% of the operational time in any 6-month reporting period
B. Performance Criteria	**Indicator**
1. Data Representativeness	The monitoring system consists of a COMS monitoring opacity across the stack as exhaust air exits the baghouse on a continuous basis
2. Verification of Operational Status	COMS digital read-out in control room
3. Quality Assurance/ Quality Control	The COMS is calibrated and maintained in accordance with 40 Code of Federal Regulations, Part 60, Appendix B, Performance Specification 1 and Graymont's Title V Quality Assurance Plan.
4. Monitoring Frequency	Continuous monitoring when affected rotary kiln is in operation
5. Data Collection Procedures	Electronic or strip charts. Opacity records and kiln system operation is maintained on site and available upon request.
6. Averaging Period	24 hours.

II. Emitting Unit: Rotary Lime Kiln #2
Pollutant: PM
Control Device: Negative Pressure Pulsed Jet Fabric Filter Baghouse
Emission Limit: 0.50 pounds per ton (lb/ton) of limestone feed
Monitoring Approach: Key elements of the monitoring approach for this CAM applicable PSEU are contained in Table II. A complete CAM plan is contained in the Graymont Western US, Inc., application for Title V operating permit renewal (#OP1554-04) and is on file with the Department. Complete copies of this CAM plan are available from the Department upon request.

CAM PLAN: TABLE II	
A. General Criteria	**Indicator**
1. Indicator	Opacity
2. Monitoring Approach	Opacity is measured and recorded continuously with a continuous opacity monitoring system (COMS)
3. Indicator Range	The indicator level is an opacity reading equal to or exceeding 12%. An excursion will be defined as any 24-hour period in which all 6-minute average opacity readings exceed 12% opacity. Opacity readings exceeding 12% opacity during periods of kiln start-up are not included in the 24-hour period evaluation.
4. Quality Improvement Plan (QIP) Threshold	The QIP threshold is excursions occurring greater than 5% of the operational time in any 6-month reporting period
B. Performance Criteria	**Indicator**
1. Data Representativeness	The monitoring system consists of a COMS monitoring opacity across the stack as exhaust air exits the baghouse on a continuous basis
2. Verification of Operational Status	COMS digital read-out in control room
3. Quality Assurance/ Quality Control	The COMS is calibrated and maintained in accordance with 40 Code of Federal Regulations, Part 60, Appendix B, Performance Specification 1 and Graymont's Title V Quality Assurance Plan.
4. Monitoring Frequency	Continuous monitoring when affected rotary kiln is in operation
5. Data Collection Procedures	Electronic or strip charts. Opacity records and kiln system operation is maintained on site and available upon request.
6. Averaging Period	24 hours.