



Maryland
Department of
the Environment

Wes Moore, Governor
Aruna Miller, Lt. Governor

Serena McIlwain, Secretary
Suzanne E. Dorsey, Deputy Secretary

Mr. Bruce Peters, Director
American Sugar Refining, Inc.
1100 Key Highway East
Baltimore, MD 21230

MAY 08 2024

Dear Mr. Peters

Re: Renewal Part 70/ Title V Operating Permit 24-510-0314 Issuance

Enclosed, please find the Renewal Part 70/Title V Operating Permit and Fact Sheet for the American Sugar Refining, Inc., located in Baltimore City. The Permit will expire on October 31, 2028.

The Code of Maryland Regulations (COMAR) 26.11.03.11 states the following:

If the Department denies a Part 70 permit or issues it with terms and conditions that are objectionable to the applicant, the applicant may request that a contested case hearing be held regarding the permit. This request shall be made to the Department in writing not later than 15 days after the applicant receives notice that the permit has been denied or of the objectionable terms and conditions. The request shall include the basis for the request and refer to any objectionable terms and conditions.

Please note the following revised condition in the Permit under Section II, General Conditions, Number 5, Permit Renewal:

The Permittee shall submit to the Department a completed application for renewal of this Part 70 permit 12 months before the expiration of the permit. Upon submitting a complete application, the Permittee may continue to operate this facility pending final action by the Department on the renewal.

If you have any questions, please feel free to contact Ms. Marcellina Gurley, at Marcie.gurley@maryland.gov or (410) 537-3230.

Sincerely,


Suna Yi Sariscak, Manager
Air Quality Permits Program
Air & Radiation Administration

SYS/jm

Enclosures

cc: EPA Region III (w/encl)
Joseph Staryarsky, EHS Manager
George Carter, Plant Manager

Wes Moore
Governor

Serena McIlwain
Secretary

State of



Maryland

DEPARTMENT OF THE ENVIRONMENT

Air and Radiation Administration
1800 Washington Boulevard, Suite 720
Baltimore, MD 21230

Construction Permit

Part 70
 Operating Permit

PERMIT NO. 24-510-0314

DATE ISSUED MAY 08 2024

PERMIT FEE To be paid in accordance with COMAR 26.11.02.19B

EXPIRATION DATE October 31, 2028

LEGAL OWNER & ADDRESS

American Sugar Refining, Inc.
1100 Key Highway East
Baltimore, MD 21230
Attn: Mr. Bruce Peters, Director

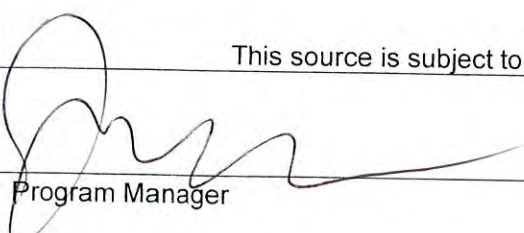
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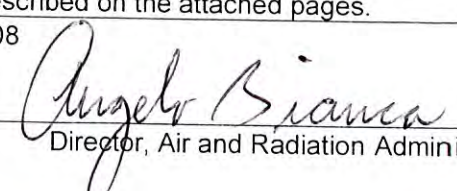
American Sugar Refining, Inc.
1100 Key Highway East
Baltimore, MD 21230
AI#60

SOURCE DESCRIPTION

One Sugar Manufacturing Plant.

This source is subject to the conditions described on the attached pages.


Program Manager


Director, Air and Radiation Administration

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

SECTION I	SOURCE IDENTIFICATION	4
1.	DESCRIPTION OF FACILITY.....	4
2.	FACILITY INVENTORY LIST.....	4
SECTION II	GENERAL CONDITIONS	9
1.	DEFINITIONS.....	9
2.	ACRONYMS.....	9
3.	EFFECTIVE DATE	10
4.	PERMIT EXPIRATION	10
5.	PERMIT RENEWAL	10
6.	CONFIDENTIAL INFORMATION.....	11
7.	PERMIT ACTIONS	11
8.	PERMIT AVAILABILITY.....	12
9.	REOPENING THE PART 70 PERMIT FOR CAUSE BY THE EPA.....	12
10.	TRANSFER OF PERMIT	12
11.	REVISION OF PART 70 PERMITS – GENERAL CONDITIONS.....	12
12.	SIGNIFICANT PART 70 OPERATING PERMIT MODIFICATIONS.....	13
13.	MINOR PERMIT MODIFICATIONS	14
14.	ADMINISTRATIVE PART 70 OPERATING PERMIT AMENDMENTS	17
15.	OFF-PERMIT CHANGES TO THIS SOURCE	19
16.	ON-PERMIT CHANGES TO SOURCES.....	20
17.	FEE PAYMENT	22
18.	REQUIREMENTS FOR PERMITS-TO-CONSTRUCT AND APPROVALS.....	22
19.	CONSOLIDATION OF PROCEDURES FOR PUBLIC PARTICIPATION	23
20.	PROPERTY RIGHTS.....	24
21.	SEVERABILITY	24
22.	INSPECTION AND ENTRY	24
23.	DUTY TO PROVIDE INFORMATION	25
24.	COMPLIANCE REQUIREMENTS.....	25
25.	CREDIBLE EVIDENCE.....	26
26.	NEED TO HALT OR REDUCE ACTIVITY NOT A DEFENSE	26
27.	CIRCUMVENTION.....	26
28.	PERMIT SHIELD	26
29.	ALTERNATE OPERATING SCENARIOS	27
SECTION III	PLANT WIDE CONDITIONS.....	28
1.	PARTICULATE MATTER FROM CONSTRUCTION AND DEMOLITION	28
2.	OPEN BURNING.....	28
3.	AIR POLLUTION EPISODE.....	28
4.	REPORT OF EXCESS EMISSIONS AND DEVIATIONS	28
5.	ACCIDENTAL RELEASE PROVISIONS.....	29
6.	GENERAL TESTING REQUIREMENTS.....	30
7.	EMISSIONS TEST METHODS	30
8.	EMISSIONS CERTIFICATION REPORT	31
9.	COMPLIANCE CERTIFICATION REPORT	32
10.	CERTIFICATION BY RESPONSIBLE OFFICIAL	33
11.	SAMPLING AND EMISSIONS TESTING RECORD KEEPING.....	33

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

12.	GENERAL RECORDKEEPING.....	34
13.	GENERAL CONFORMITY.....	34
14.	ASBESTOS PROVISIONS	34
15.	OZONE DEPLETING REGULATIONS.....	35
16.	ACID RAIN PERMIT	35
SECTION IV	PLANT SPECIFIC CONDITIONS.....	36
SECTION V	INSIGNIFICANT ACTIVITIES	97
SECTION VI	STATE-ONLY ENFORCEABLE CONDITIONS	107

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

SECTION I SOURCE IDENTIFICATION

1. DESCRIPTION OF FACILITY

American Sugar Refining, Inc. (ASR) operates a sugar manufacturing plant which produces granulated and confectioner's sugars from raw cane sugar in bulk quantities and in various package sizes. The facility also manufactures bulk quantities of liquid cane sugars and syrups for industrial consumption. The sugar manufacturing process consists of two principal processes: decolorization and sugar production. The facility also operates a centralized steam and electrical cogeneration energy production facility (powerhouse). There are four (4) boilers (130 million Btu/hr. each) which fire natural gas and that fire fuel oil (No. 2 or No. 6) in curtailment and testing situations. There is also one (1) boiler which will be rated at 300 million Btu/hr. that burns natural gas only.

The sugar manufacturing plant is located at 1100 Key Highway East in Baltimore, Maryland. The primary SIC code for this facility is 2062, sugar cane refining.

2. FACILITY INVENTORY LIST

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
C1 thru C4	5-1444 thru 5-1447	Four (4) Combustion Engineering Boilers, each rated at 130 million Btu/hr. firing natural gas and No. 2 fuel oil. Boilers 1 thru 4.	1966; Modified 6/12/2012
C6	5-1476	One (1) Babcock & Wilcox boiler rated at 300 million Btu/hr. firing natural gas and equipped with a low-NO _x burner and flue gas recirculation.	July 2000; Modified 1/18/2013 and 2018
R29-1	6-3091	Raw Sugar Unloading and Conveying. Modified 2021: additional equipment for transfer of raw sugar – Old Sugar Shed Conveyance system to/from Storage Barge. [PTC issued Aug 5, 2021]	Aug 2021
R29-3	N/A	Melter Feed	1971
R29-4	N/A	Diatomite Fugitives	1971
S7B-2	8-0212	Bin Tower Rejects Box	1966
S7-12	8-0266	Maltodex Supersak Unloading System	1982
S7-13	N/A	Remelt Shredder Fugitives	1989
S7-14	8-0223	Magnets Tailing Fugitives	1966
D28-1	8-0301	Carbonatation Process – Lime silo equipped with a baghouse	1995

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
D10-1, 2, 3	8-0301	Carbonatation Process – Saturators demisters (RP-C-1, -2, -3, respectively) and controlled by a Ducon Flue Gas Scrubber.	1995
D2-1		Mud Loading	1964
D3-5	N/A	Char Filtration Process – Celite Fugitives	
U5-1	8-0383	Cooling Tower CT-3	Unknown
S5-1	8-0226	Scrap melter equipped with a Rotoclone scrubber (RP-C-1)	1922
S5-2	8-0382	Scrap melter	1991
S5-3		Remelt Screw Conveyors	1991
S5-4	6-2022	Invert System with a Rotoclone [S5-4A: Invert Cloudy Tank; S5-4B: Invert Precoat Tank; S5-4C: Surcose Cloudy Tank; S5-4D: Surcose Precoat Tank; S5-4E: Clear Surcose Tank; S5-4F: Clear Invert Tank]	1958
S5-5		Caustic fugitives associated with the invert System	1958
S5-6	6-2020	Soft Sugar Shredder	1969
S5-8A-B	8-0332	Two (2) Dryers (Powdered Specialty Sugars) each equipped with venturi scrubbers (DW-1) (RP-C-33), DW-2 (RP-C-34), respectively.	Feb 2004
S5-8D		Liquid Sugar Cooler (Powdered Specialty Sugars) controlled by Sly Venturi Scrubber (WS-1) (RP-C-35).	Feb 2004
S5-8E		Three (3) Centrifugal Separators controlled by Sly Venturi Scrubber (WS-1) (RP-C-36)	Feb 2004
S5-8F		Washout Tanks and Beater controlled by a Rotoclone.	Feb 2004
S5-8G		Packaging and Conveying Equipment controlled by Sly Venturi Scrubber (WS-1) (RP-C-36)	Feb 2004
S1-1	8-0320	FEECO Rotary sugar dryer equipped with Entoleter vortex scrubber (RP-C-15)	1999
S7A-1	8-0212	Bulk Sugar Conveying System controlled by a scrubber (RP-C-25) [S7A-RE1: Bucket Elevator RE-1; S7A-XE1: Bucket Elevator XE-1; S7A-XRS1: Bucket Elevator XRS-1; S7A-UE1: Bucket Elevator UE-1; S7A-UE2A: Bucket Elevator UE-2A; S7A-UE2B: Bucket Elevator UE-2B; S7A-RE2: Bucket Elevator RE-2;	1966

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
		S7A-U1: Storage Bin U1; S7A-U2: Storage Bin U2; S7A-U3: Storage Bin U3; S7A-U4: Storage Bin U4; S7A-U5: Storage Bin U5; S7A-U6: Storage Bin U6; S7A-XF1: Storage Bin XF-1; S7A-XF2: Storage Bin XF-2; S7A-V1: Storage Bin V1; S7A-V2: Storage Bin V2; S7A-V3: Storage Bin V3; S7A-V4: Storage Bin V4; S7A-V5: Storage Bin V5; S7A-V6: Storage Bin V6; S7A-C1: Storage Bin C1; S7A-F1: Storage Bin F1; S7A-AR1: Storage Bin AR1; S7A-AR2: Storage Bin AR2; S7A-AR3: Storage Bin AR3; S7A-AR4: Storage Bin AR4; S7A-AR5: Storage Bin AR5; S7A-AR6: Storage Bin AR6; S7A-AR7: Storage Bin AR7; S7A-AR8: Storage Bin AR8; S7A-RJX: Screw Conveyor Rejects.	
S7-5, S7-6, S7-7	8-0265	Packaging Feed Tanks each equipped with a filter (RP-C-26, -27, & -28, respectively)	Jan 2001
S7-8		Packaging Operations controlled by Rotoclone 7-6-1 (RP-C-29) [S7-8A: Fawema Packaging System; S7-8B: Paxall Packaging System; S7-8C: Clouds Packaging System; S7-8D: Handi Pak System]	Jan 2001
S7-10		Packaging System controlled by a Wheelabrator dust collector (7-5-1) (RP-C-32) [S7-10A: Hesser Bagging System; S7-10B: Supersack Unloading System]	Jan 2001
S7B-1	8-0223	Bulk Loading System with an Entoleter scrubber (RP-C-31) and DCL UN800 Dust Collectors	1966; Modified Feb 2016
S7-11	8-0287	Supersack Sugar Packing Line controlled by Wheelabrator dust collectors. [S7-11A: Thiele Supersack system;	1990

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
		S7-11B: Tub Packaging Line controlled by Wheelabrator 7-5-2 (RP-C-30); S7-11C: Simplex Packaging Line controlled by a Wheelabrator dust collector 6-5-1 (RP-C-12)]	
S6-4	8-0115	BMA Granulator equipped with Rotoclone (RP-C-11)	1969
S6-5	8-0225	Sugar Packaging Line and Conveying System controlled by a Wheelabrator dry filter (6-5-1) (RP-C-12) [S6-5A: Remelt Shredder; S6-5B: Maltrin Tank; S6-5C: Sugar Tank; S6-5D: MFB Feeder; S6-5E-G: 3 Sugar Feed to Mills 1, 2, & 3; S6-5H: 6-5-1200 Receiver; S6-5I: UB-1 South Hood; S6-5J: UB-1 Tail End]	Nov 2008; Modified Apr 2021
S6-6	8-0115	Sugar Packaging Line and Conveying System controlled by a Wheelabrator dry filter (6-5-2) (RP-C-13) [S6-6A: Oscillator; S6-6B: DSE-1; S6-6C: US-2 Scroll; S6-6D: UB-1 North]	Nov 2008
S6-7	8-0296 / 8-0409	Sugar Packaging Line and Conveying System controlled by a Wheelabrator dry filter (6-5-3) (RP-C-14) [S6-7A: Receiver 1300 2#; S6-7B: Old V-Bag Packaging System; S6-7C: Receiver 1250; S6-7D: Receiver 6-4-1300; S6-7E: 2# Poly Filler System; S6-7F: New V.B. Filler System; S6-7G: Old V.B Filler System; S6-7H: Packet Grinder; S6-7I: 1-4 10X Filler System; S6-7J: Bulkline (Supersack) Packaging Line – June 2020 – MDE Reg. 510-0314-8-0409]	Nov 2008 / Jun 2020; Modified Apr. 2021
S6-1	8-0209	Sugar Mill 1 equipped with MAC dry filer (RP-C-16)	Nov 2008
S6-1A		Starch Receiver 1 equipped with dry filer (RP-C-17)	Nov 2008
S6-2		Sugar Mill 2 equipped with MAC dry filer (RP-C-18)	Nov 2008

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
S6-2A		Starch Receiver 2 equipped with dry filer (RP-C-19)	Nov 2008
S6-3	8-0125	Sugar Mill 3 equipped with MAC dry filer (RP-C-20)	Nov 2008
S6-3A		Starch Receiver 3 equipped with dry filer (RP-C-21)	Nov 2008
S6-8	8-0266	Sugar Pulverizer (Mill 7) equipped with Mikropul baghouse (RP-C-24)	1988
S6-9	8-0209	Starch Bin equipped with vent filter (RP-C-22)	Nov 2008
S5-7	6-2021	Ten (10) Evaporation Pans (#1-9, 11)	1950
S7-15	6-2018	Packaging Video Inkjet Printers	1990
S7-16	9-1298	Packaging Adhesives Fugitives: additional adhesive (H.B. Fuller – Swift@Tak 5948-00) for substitution of original adhesives.	1990; Mod. 2022
D3-6	8-0386	Ion Exchange System: Scrubber (25-gpm once-through)	2013
D3-6A		HCl Tank (8,450-gallons) equipped with scrubber D3-6	
D3-7		Resin Acid Wash Tank (12,924-gallons)	
D3-8		Clean in Place (CIP) Tank (734-gallons)	
D3-9A, B, C, D		Four (4) Deashing Resin Beds (10,574-gallon, each)	
D3-10A, B, C, D		Four (4) Decolorized Resin Beds (23,603-gallons, each)	
D3-11A, B		Two (2) Salt saturators controlled by water spray chamber (D3-11)	
D3-12		HCl equipment leak components (valves, pumps, connectors)	
U11-2	9-1293	250-kW Emergency Generator	
S1, S2, S3 & S4	8-0411	Four (4) 3.75-million-pound sugar storage silos equipped with bin vents (BV-1, BV-2, BV-3, BV-4) [PTC issued Feb 25, 2021]	2021

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

SECTION II GENERAL CONDITIONS

1. DEFINITIONS

[COMAR 26.11.01.01] and [COMAR 26.11.02.01]

The words or terms in this Part 70 permit shall have the meanings established under COMAR 26.11.01 and .02 unless otherwise stated in this permit.

2. ACRONYMS

ARA	Air and Radiation Administration
BACT	Best Available Control Technology
Btu	British thermal unit
CAA	Clean Air Act
CAM	Compliance Assurance Monitoring
CEM	Continuous Emissions Monitor
CFR	Code of Federal Regulations
CO	Carbon Monoxide
COMAR	Code of Maryland Regulations
EPA	United States Environmental Protection Agency
FR	Federal Register
gr	grains
HAP	Hazardous Air Pollutant
MACT	Maximum Achievable Control Technology
MDE	Maryland Department of the Environment
MVAC	Motor Vehicle Air Conditioner
NESHAPS	National Emission Standards for Hazardous Air Pollutants
NO _x	Nitrogen Oxides
NSPS	New Source Performance Standards
NSR	New Source Review
OTR	Ozone Transport Region
PM	Particulate Matter
PM10	Particulate Matter with Nominal Aerodynamic Diameter of 10 micrometers or less
ppm	parts per million
ppb	parts per billion
PSD	Prevention of Significant Deterioration
PTC	Permit to construct
PTO	Permit to operate (State)
SIC	Standard Industrial Classification
SO ₂	Sulfur Dioxide

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

TAP	Toxic Air Pollutant
tpy	tons per year
VE	Visible Emissions
VOC	Volatile Organic Compounds

3. EFFECTIVE DATE

The effective date of the conditions in this Part 70 permit is the date of permit issuance, unless otherwise stated in the permit.

4. PERMIT EXPIRATION

[COMAR 26.11.03.13B(2)]

Upon expiration of this permit, the terms of the permit will automatically continue to remain in effect until a new Part 70 permit is issued for this facility provided that the Permittee has submitted a timely and complete application and has paid applicable fees under COMAR 26.11.02.16.

Otherwise, upon expiration of this permit the right of the Permittee to operate this facility is terminated.

5. PERMIT RENEWAL

[COMAR 26.11.03.02B(3)] and [COMAR 26.11.03.02E]

The Permittee shall submit to the Department a completed application for renewal of this Part 70 permit at least 12 months before the expiration of the permit. Upon submitting a completed application, the Permittee may continue to operate this facility pending final action by the Department on the renewal.

The Permittee, upon becoming aware that any relevant facts were omitted or incorrect information was submitted in the permit application, shall submit such supplementary facts or corrected information no later than 10 days after becoming aware that this occurred. The Permittee shall also provide additional information as necessary to address any requirements that become applicable to the facility after the date a completed application was submitted, but prior to the release of a draft permit. This information shall be submitted to the Department no later than 20 days after a new requirement has been adopted.

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

6. CONFIDENTIAL INFORMATION

[COMAR 26.11.02.02G]

In accordance with the provisions of the State Government Article, Sec. 10-611 et seq., Annotated Code of Maryland, all information submitted in an application shall be considered part of the public record and available for inspection and copying, unless the Permittee claims that the information is confidential when it is submitted to the Department. At the time of the request for inspection or copying, the Department will make a determination with regard to the confidentiality of the information. The Permittee, when requesting confidentiality, shall identify the information in a manner specified by the Department and, when requested by the Department, promptly provide specific reasons supporting the claim of confidentiality. Information submitted to the Department without a request that the information be deemed confidential may be made available to the public. Subject to approval of the Department, the Permittee may provide a summary of confidential information that is suitable for public review. The content of this Part 70 permit is not subject to confidential treatment.

7. PERMIT ACTIONS

[COMAR 26.11.03.06E(3)] and [COMAR 26.11.03.20(A)]

This Part 70 permit may be revoked or reopened and revised for cause. The filing of an application by the Permittee for a permit revision or renewal; or a notification of termination, planned changes or anticipated noncompliance by the facility, does not stay a term or condition of this permit.

The Department shall reopen and revise, or revoke the Permittee's Part 70 permit under the following circumstances:

- a. Additional requirements of the Clean Air Act become applicable to this facility and the remaining permit term is 3 years or more;
- b. The Department or the EPA determines that this Part 70 permit contains a material mistake, or is based on false or inaccurate information supplied by or on behalf of the Permittee;

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

- c. The Department or the EPA determines that this Part 70 permit must be revised or revoked to assure compliance with applicable requirements of the Clean Air Act; or
- d. Additional requirements become applicable to an affected source under the Federal Acid Rain Program.

8. PERMIT AVAILABILITY

[COMAR 26.11.02.13G]

The Permittee shall maintain this Part 70 permit in the vicinity of the facility for which it was issued, unless it is not practical to do so, and make this permit immediately available to officials of the Department upon request.

9. REOPENING THE PART 70 PERMIT FOR CAUSE BY THE EPA

[COMAR 26.11.03.20B]

The EPA may terminate, modify, or revoke and reissue a permit for cause as prescribed in 40 CFR §70.7(g)

10. TRANSFER OF PERMIT

[COMAR 26.11.02.02E]

The Permittee shall not transfer this Part 70 permit except as provided in COMAR 26.11.03.15.

11. REVISION OF PART 70 PERMITS – GENERAL CONDITIONS

[COMAR 26.11.03.14] and [COMAR 26.11.03.06A(8)]

- a. The Permittee shall submit an application to the Department to revise this Part 70 permit when required under COMAR 26.11.03.15 -.17.
- b. When applying for a revision to a Part 70 permit, the Permittee shall comply with the requirements of COMAR 26.11.03.02 and .03 except that the application for a revision need include only information listed that is related to the proposed change to the source and revision to

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

the permit. This information shall be sufficient to evaluate the proposed change and to determine whether it will comply with all applicable requirements of the Clean Air Act.

- c. The Permittee may not change any provision of a compliance plan or schedule in a Part 70 permit as an administrative permit amendment or as a minor permit modification unless the change has been approved by the Department in writing.
- d. A permit revision is not required for a change that is provided for in this permit relating to approved economic incentives, marketable permits, emissions trading, and other similar programs.

12. SIGNIFICANT PART 70 OPERATING PERMIT MODIFICATIONS

[COMAR 26.11.03.17]

The Permittee may apply to the Department to make a significant modification to its Part 70 Permit as provided in COMAR 26.11.03.17 and in accordance with the following conditions:

- a. A significant modification is a revision to the federally enforceable provisions in the permit that does not qualify as an administrative permit amendment under COMAR 26.11.03.15 or a minor permit modification as defined under COMAR 26.11.03.16.
- b. This permit does not preclude the Permittee from making changes, consistent with the provisions of COMAR 26.11.03, that would make the permit or particular terms and conditions of the permit irrelevant, such as by shutting down or reducing the level of operation of a source or of an emissions unit within the source. Air pollution control equipment shall not be shut down or its level of operation reduced if doing so would violate any term of this permit.
- c. Significant permit modifications are subject to all requirements of COMAR 26.11.03 as they apply to permit issuance and renewal, including the requirements for applications, public participation, and review by affected states and EPA, except:
 - (1) An application need include only information pertaining to the proposed change to the source and modification of this permit, including a description of the change and modification, and any

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

new applicable requirements of the Clean Air Act that will apply if the change occurs;

- (2) Public participation, and review by affected states and EPA, is limited to only the application and those federally enforceable terms and conditions of the Part 70 permit that are affected by the significant permit modification.
- d. As provided in COMAR 26.11.03.15B(5), an administrative permit amendment may be used to make a change that would otherwise require a significant permit modification if procedures for enhanced preconstruction review of the change are followed that satisfy the requirements of 40 CFR 70.7(d)(1)(v).
- e. Before making a change that qualifies as a significant permit modification, the Permittee shall obtain all permits-to-construct and approvals required by COMAR 26.11.02.
- f. The Permittee shall not make a significant permit modification that results in a violation of any applicable requirement of the Clean Air Act.
- g. The permit shield in COMAR 26.11.03.23 applies to a final significant permit modification that has been issued by the Department, to the extent applicable under COMAR 26.11.03.23.

13. MINOR PERMIT MODIFICATIONS

[COMAR 26.11.03.16]

The Permittee may apply to the Department to make a minor modification to the federally enforceable provisions of this Part 70 permit as provided in COMAR 26.11.03.16 and in accordance with the following conditions:

- a. A minor permit modification is a Part 70 permit revision that:
 - (1) Does not result in a violation of any applicable requirement of the Clean Air Act;
 - (2) Does not significantly revise existing federally enforceable monitoring, including test methods, reporting, record keeping, or compliance certification requirements except by:

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- (a) Adding new requirements,
 - (b) Eliminating the requirements if they are rendered meaningless because the emissions to which the requirements apply will no longer occur, or
 - (c) Changing from one approved test method for a pollutant and source category to another;
- (3) Does not require or modify a:
- (a) Case-by-case determination of a federally enforceable emissions standard,
 - (b) Source specific determination for temporary sources of ambient impacts, or
 - (c) Visibility or increment analysis;
- (4) Does not seek to establish or modify a federally enforceable permit term or condition for which there is no corresponding underlying applicable requirement of the Clean Air Act, but that the Permittee has assumed to avoid an applicable requirement to which the source would otherwise be subject, including:
- (a) A federally enforceable emissions standard applied to the source pursuant to COMAR 26.11.02.03 to avoid classification as a Title I modification; and
 - (b) An alternative emissions standard applied to an emissions unit pursuant to regulations promulgated under Section 112(i)(5) of the Clean Air Act
- (5) Is not a Title I modification; and
- (6) Is not required under COMAR 26.11.03.17 to be processed as a significant modification to this Part 70 permit.
- b. Application for a Minor Permit Modification

The Permittee shall submit to the Department an application for a minor permit modification that satisfies the requirements of COMAR 26.11.03.03 which includes the following:

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- (1) A description of the proposed change, the emissions resulting from the change, and any new applicable requirements that will apply if the change is made;
 - (2) The proposed minor permit modification;
 - (3) Certification by a responsible official, in accordance with COMAR 26.11.02.02F, that:
 - (a) The proposed change meets the criteria for a minor permit modification, and
 - (b) The Permittee has obtained or applied for all required permits-to-construct required by COMAR 26.11.03.16 with respect to the proposed change;
 - (4) Completed forms for the Department to use to notify the EPA and affected states, as required by COMAR 26.11.03.07-.12.
- c. Permittee's Ability to Make Change
- (1) For changes proposed as minor permit modifications to this permit that will require the applicant to obtain a permit to construct, the permit to construct must be issued prior to the new change.
 - (2) During the period of time after the Permittee applies for a minor modification but before the Department acts in accordance with COMAR 26.11.03.16F(2):
 - (a) The Permittee shall comply with applicable requirements of the Clean Air Act related to the change and the permit terms and conditions described in the application for the minor modification.
 - (b) The Permittee is not required to comply with the terms and conditions in the permit it seeks to modify. If the Permittee fails to comply with the terms and conditions in the application during this time, the terms and conditions of both this permit and the application for modification may be enforced against it.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- d. The Permittee is subject to enforcement action if it is determined at any time that a change made under COMAR 26.11.03.16 is not within the scope of this regulation.
- e. Minor permit modification procedures may be used for Part 70 permit modifications involving the use of economic incentives, marketable permits, emissions trading, and other similar approaches, but only to the extent that the minor permit modification procedures are explicitly provided for in regulations approved by the EPA as part of the Maryland SIP or in other applicable requirements of the Clean Air Act.

14. ADMINISTRATIVE PART 70 OPERATING PERMIT AMENDMENTS

[COMAR 26.11.03.15]

The Permittee may apply to the department to make an administrative permit amendment as provided in COMAR 26.11.03.15 and in accordance with the following conditions:

- a. An application for an administrative permit amendment shall:
 - (1) Be in writing;
 - (2) Include a statement certified by a responsible official that the proposed amendment meets the criteria in COMAR 26.11.03.15 for an administrative permit amendment, and
 - (3) Identify those provisions of this part 70 permit for which the amendment is requested, including the basis for the request.
- b. An administrative permit amendment:
 - (1) Is a correction of a typographical error;
 - (2) Identifies a change in the name, address, or phone number of a person identified in this permit, or a similar administrative change involving the Permittee or other matters which are not directly related to the control of air pollution;
 - (3) requires more frequent monitoring or reporting by the Permittee;

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- (4) Allows for a change in ownership or operational control of a source for which the Department determines that no other revision to the permit is necessary and is documented as per COMAR 26.11.03.15B(4);
 - (5) Incorporates into this permit the requirements from preconstruction review permits or approvals issued by the Department in accordance with COMAR 26.11.03.15B(5), but only if it satisfies 40 CFR 70.7(d)(1)(v);
 - (6) Incorporates any other type of change, as approved by the EPA, which is similar to those in COMAR 26.11.03.15B(1)—(4);
 - (7) Notwithstanding COMAR 26.11.03.15B(1)—(6), all modifications to acid rain control provisions included in this Part 70 permit are governed by applicable requirements promulgated under Title IV of the Clean Air Act; or
 - (8) Incorporates any change to a term or condition specified as State-only enforceable if the Permittee has obtained all necessary permits-to-construct and approvals that apply to the change.
- c. The Permittee may make the change addressed in the application for an administrative amendment upon receipt by the Department of the application if all permits-to-construct or approvals otherwise required by COMAR 26.11.02 prior to making the change have first been obtained from the Department.
 - d. The permit shield in COMAR 26.11.03.23 applies to administrative permit amendments made under Section B(5) of COMAR 26.11.03.15 , but only after the Department takes final action to revise the permit.
 - e. The Permittee is subject to enforcement action if it is determined at any time that a change made under COMAR 26.11.03.15 is not within the scope of this regulation.

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

15. OFF-PERMIT CHANGES TO THIS SOURCE

[COMAR 26.11.03.19]

The Permittee may make off-permit changes to this facility as provided in COMAR 26.11.03.19 and in accordance with the following conditions:

- a. The Permittee may make a change to this permitted facility that is not addressed or prohibited by the federally enforceable conditions of this Part 70 permit without obtaining a Part 70 permit revision if:
 - (1) The Permittee has obtained all permits and approvals required by COMAR 26.11.02 and .03;
 - (2) The change is not subject to any requirements under Title IV of the Clean Air Act;
 - (3) The change is not a Title I modification; and
 - (4) The change does not violate an applicable requirement of the Clean Air Act or a federally enforceable term or condition of the permit.
- b. For a change that qualifies under COMAR 26.11.03.19, the Permittee shall provide contemporaneous written notice to the Department and the EPA, except for a change to an emissions unit or activity that is exempt from the Part 70 permit application, as provided in COMAR 26.11.03.04. This written notice shall describe the change, including the date it was made, any change in emissions, including the pollutants emitted, and any new applicable requirements of the Clean Air Act that apply as a result of the change.
- c. Upon satisfying the requirements of COMAR 26.11.03.19, the Permittee may make the proposed change.
- d. The Permittee shall keep a record describing:
 - (1) Changes made at the facility that result in emissions of a regulated air pollutant subject to an applicable requirement of the Clean Air Act, but not otherwise regulated under this permit; and
 - (2) The emissions resulting from those changes.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- e. Changes that qualify under COMAR 26.11.03.19 are not subject to the requirements for Part 70 revisions.
- f. The Permittee shall include each off-permit change under COMAR 26.11.03.19 in the application for renewal of the part 70 permit.
- g. The permit shield in COMAR 26.11.03.23 does not apply to off-permit changes made under COMAR 26.11.03.19.
- h. The Permittee is subject to enforcement action if it is determined that an off-permit change made under COMAR 26.11.03.19 is not within the scope of this regulation.

16. ON-PERMIT CHANGES TO SOURCES

[COMAR 26.11.03.18]

The Permittee may make on-permit changes that are allowed under Section 502(b)(10) of the Clean Air Act as provided in COMAR 26.11.03.18 and in accordance with the following conditions:

- a. The Permittee may make a change to this facility without obtaining a revision to this Part 70 permit if:
 - (1) The change is not a Title I modification;
 - (2) The change does not result in emissions in excess of those expressly allowed under the federally enforceable provisions of the Part 70 permit for the permitted facility or for an emissions unit within the facility, whether expressed as a rate of emissions or in terms of total emissions;
 - (3) The Permittee has obtained all permits and approvals required by COMAR 26.11.02 and .03;
 - (4) The change does not violate an applicable requirement of the Clean Air Act;
 - (5) The change does not violate a federally enforceable permit term or condition related to monitoring, including test methods, record keeping, reporting, or compliance certification requirements;

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- (6) The change does not violate a federally enforceable permit term or condition limiting hours of operation, work practices, fuel usage, raw material usage, or production levels if the term or condition has been established to limit emissions allowable under this permit;
 - (7) If applicable, the change does not modify a federally enforceable provision of a compliance plan or schedule in this Part 70 permit unless the Department has approved the change in writing; and
 - (8) This permit does not expressly prohibit the change under COMAR 26.11.03.18.
- b. The Permittee shall notify the Department and the EPA in writing of a proposed on-permit change under COMAR 26.11.03.18 not later than 7 days before the change is made. The written information shall include the following information:
- (1) A description of the proposed change;
 - (2) The date on which the change is proposed to be made;
 - (3) Any change in emissions resulting from the change, including the pollutants emitted;
 - (4) Any new applicable requirement of the Clean Air Act; and
 - (5) Any permit term or condition that would no longer apply.
- c. The responsible official of this facility shall certify in accordance with COMAR 26.11.02.02F that the proposed change meets the criteria for the use of on-permit changes under COMAR 26.11.03.18.
- d. The Permittee shall attach a copy of each notice required by condition b. above to this Part 70 permit.
- e. On-permit changes that qualify under COMAR 26.11.03.18 are not subject to the requirements for part 70 permit revisions.
- f. Upon satisfying the requirements under COMAR 26.11.03.18, the Permittee may make the proposed change.

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

- g. The permit shield in COMAR 26.11.03.23 does not apply to on-permit changes under COMAR 26.11.03.18.
- h. The Permittee is subject to enforcement action if it is determined that an on-permit change made under COMAR 26.11.03.18 is not within the scope of the regulation or violates any requirement of the State air pollution control law.

17. FEE PAYMENT

[COMAR 26.11.02.16A(2) & (5)(b)]

- a. The fee for this Part 70 permit is as prescribed in Regulation .19 of COMAR 26.11.02.
- b. The fee is due on and shall be paid on or before each 12-month anniversary date of the permit.
- c. Failure to pay the annual permit fee constitutes cause for revocation of the permit by the Department.

18. REQUIREMENTS FOR PERMITS-TO-CONSTRUCT AND APPROVALS

[COMAR 26.11.02.09.]

The Permittee may not construct or modify or cause to be constructed or modified any of the following sources without first obtaining, and having in current effect, the specified permits-to-construct and approvals:

- a. New Source Review source, as defined in COMAR 26.11.01.01, approval required, except for generating stations constructed by electric companies;
- b. Prevention of Significant Deterioration source, as defined in COMAR 26.11.01.01, approval required, except for generating stations constructed by electric companies;
- c. New Source Performance Standard source, as defined in COMAR 26.11.01.01, permit to construct required, except for generating stations constructed by electric companies;

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

- d. National Emission Standards for Hazardous Air Pollutants source, as defined in COMAR 26.11.01.01, permit to construct required, except for generating stations constructed by electric companies;
- e. A stationary source of lead that discharges one ton per year or more of lead or lead compounds measured as elemental lead, permit to construct required, except for generating stations constructed by electric companies;
- f. All stationary sources of air pollution, including installations and air pollution control equipment, except as listed in COMAR 26.11.02.10, permit to construct required;
- g. In the event of a conflict between the applicability of (a.— e.) above and an exemption listed in COMAR 26.11.02.10, the provision that requires a permit applies.
- h. Approval of a PSD or NSR source by the Department does not relieve the Permittee obtaining an approval from also obtaining all permits-to-construct required by (c.— g.) above.

19. CONSOLIDATION OF PROCEDURES FOR PUBLIC PARTICIPATION

[COMAR 26.11.02.11C] and [COMAR 26.11.03.01K]

The Permittee may request the Department to authorize special procedures for the Permittee to apply simultaneously, to the extent possible, for a permit to construct and a revision to this permit.

These procedures may provide for combined public notices, informational meetings, and public hearings for both permits but shall not adversely affect the rights of a person, including EPA and affected states, to obtain information about the application for a permit, to comment on an application, or to challenge a permit that is issued.

These procedures shall not alter any existing permit procedures or time frames.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

20. PROPERTY RIGHTS

[COMAR 26.11.03.06E(4)]

This Part 70 permit does not convey any property rights of any sort, or any exclusive privileges.

21. SEVERABILITY

[COMAR 26.11.03.06A(5)]

If any portion of this Part 70 permit is challenged, or any term or condition deemed unenforceable, the remainder of the requirements of the permit continues to be valid.

22. INSPECTION AND ENTRY

[COMAR 26.11.03.06G(3)]

The Permittee shall allow employees and authorized representatives of the Department, the EPA, and local environmental health agencies, upon presentation of credentials or other documents as may be required by law, to:

- a. Enter at a reasonable time without delay and without prior notification the Permittee's property where a Part 70 source is located, emissions-related activity is conducted, or records required by this permit are kept;
- b. Have access to and make copies of records required by the permit;
- c. Inspect all emissions units within the facility subject to the permit and all related monitoring systems, air pollution control equipment, and practices or operations regulated or required by the permit; and
- d. Sample or monitor any substances or parameters at or related to the emissions units at the facility for the purpose of determining compliance with the permit.

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

23. DUTY TO PROVIDE INFORMATION

[COMAR 26.11.03.06E(5)]

The Permittee shall furnish to the Department, within a reasonable time specified by the Department, information requested in writing by the Department in order to determine whether the Permittee is in compliance with the federally enforceable conditions of this Part 70 permit, or whether cause exists for revising or revoking the permit. Upon request, the Permittee shall also furnish to the Department records required to be kept under the permit.

For information claimed by the Permittee to be confidential and therefore potentially not discloseable to the public, the Department may require the Permittee to provide a copy of the records directly to the EPA along with a claim of confidentiality.

The Permittee shall also furnish to the Department, within a reasonable time specified by the Department, information or records requested in writing by the Department in order to determine if the Permittee is in compliance with the State-only enforceable conditions of this permit.

24. COMPLIANCE REQUIREMENTS

[COMAR 26.11.03.06E(1)] and [COMAR 26.11.03.06A(11)] and [COMAR 26.11.02.05]

The Permittee shall comply with the conditions of this Part 70 permit. Noncompliance with the permit constitutes a violation of the Clean Air Act, and/or the Environment Article Title 2 of the Annotated Code of Maryland and may subject the Permittee to:

- a. Enforcement action,
- b. Permit revocation or revision,
- c. Denial of the renewal of a Part 70 permit, or
- d. Any combination of these actions.

The conditions in this Part 70 permit are enforceable by EPA and citizens under the Clean Air Act except for the State-only enforceable conditions.

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

Under Environment Article Section 2-609, Annotated Code of Maryland, the Department may seek immediate injunctive relief against a person who violates this permit in such a manner as to cause a threat to human health or the environment.

25. CREDIBLE EVIDENCE

Nothing in this permit shall be interpreted to preclude the use of credible evidence to demonstrate noncompliance with any term of this permit.

26. NEED TO HALT OR REDUCE ACTIVITY NOT A DEFENSE

[COMAR 26.11.03.06E(2)]

The need to halt or reduce activity in order to comply with the conditions of this permit may not be used as a defense in an enforcement action.

27. CIRCUMVENTION

[COMAR 26.11.01.06]

The Permittee may not install or use any article, machine, equipment or other contrivance, the use of which, without resulting in a reduction in the total weight of emissions, conceals or dilutes emissions which would otherwise constitute a violation of any applicable air pollution control regulation.

28. PERMIT SHIELD

[COMAR 26.11.03.23]

A permit shield as described in COMAR 26.11.03.23 shall apply only to terms and conditions in this Part 70 permit that have been specifically identified as covered by the permit shield. Neither this permit nor COMAR 26.11.03.23 alters the following:

- a. The emergency order provisions in Section 303 of the Clean Air Act, including the authority of EPA under that section;

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- b. The liability of the Permittee for a violation of an applicable requirement of the Clean Air Act before or when this permit is issued or for a violation that continues after issuance;
- c. The requirements of the Acid Rain Program, consistent with Section 408(a) of the Clean Air Act;
- d. The ability of the Department or EPA to obtain information from a source pursuant to Maryland law and Section 114 of the Clean Air Act; or
- e. The authority of the Department to enforce an applicable requirement of the State air pollution control law that is not an applicable requirement of the Clean Air Act.

29. ALTERNATE OPERATING SCENARIOS

[COMAR 26.11.03.06A(9)]

For all alternate operating scenarios approved by the Department and contained within this permit, the Permittee, while changing from one approved scenario to another, shall contemporaneously record in a log maintained at the facility each scenario under which the emissions unit is operating and the date and time the scenario started and ended.

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

SECTION III PLANT WIDE CONDITIONS

1. PARTICULATE MATTER FROM CONSTRUCTION AND DEMOLITION

[COMAR 26.11.06.03D]

The Permittee shall not cause or permit any building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne.

2. OPEN BURNING

[COMAR 26.11.07]

Except as provided in COMAR 26.11.07.04, the Permittee shall not cause or permit an open fire from June 1 through August 31 of any calendar year. Prior to any open burning, the Permittee shall request and receive approval from the Department.

3. AIR POLLUTION EPISODE

[COMAR 26.11.05.04]

When requested by the Department, the Permittee shall prepare in writing standby emissions reduction plans, consistent with good industrial practice and safe operating procedures, for reducing emissions creating air pollution during periods of Alert, Warning, and Emergency of an air pollution episode.

4. REPORT OF EXCESS EMISSIONS AND DEVIATIONS

[COMAR 26.11.01.07] and [COMAR 26.11.03.06C(7)]

The Permittee shall comply with the following conditions for occurrences of excess emissions and deviations from requirements of this permit, including those in Section VI – State-only Enforceable Conditions:

- a. Report any deviation from permit requirements that could endanger human health or the environment, by orally notifying the Department immediately upon discovery of the deviation;

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

- b. Promptly report all occurrences of excess emissions that are expected to last for one hour or longer by orally notifying the Department of the onset and termination of the occurrence;
- c. When requested by the Department the Permittee shall report all deviations from permit conditions, including those attributed to malfunctions as defined in COMAR 26.11.01.07A, within 5 days of the request by submitting a written description of the deviation to the Department. The written report shall include the cause, dates and times of the onset and termination of the deviation, and an account of all actions planned or taken to reduce, eliminate, and prevent recurrence of the deviation;
- d. The Permittee shall submit to the Department semi-annual monitoring reports that confirm that all required monitoring was performed, and that provide accounts of all deviations from permit requirements that occurred during the reporting periods. Reporting periods shall be January 1 through June 30 and July 1 through December 31, and reports shall be submitted within 30 days of the end of each reporting period. Each account of deviation shall include a description of the deviation, the dates and times of onset and termination, identification of the person who observed or discovered the deviation, causes and corrective actions taken, and actions taken to prevent recurrence. If no deviations from permit conditions occurred during a reporting period, the Permittee shall submit a written report that so states.
- e. When requested by the Department, the Permittee shall submit a written report to the Department within 10 days of receiving the request concerning an occurrence of excess emissions. The report shall contain the information required in COMAR 26.11.01.07D(2).

5. ACCIDENTAL RELEASE PROVISIONS

[COMAR 26.11.03.03B(23)] and [40 CFR 68]

Should the Permittee become subject to 40 CFR 68 during the term of this permit, the Permittee shall submit risk management plans by the date specified in 40 CFR 68.150 and shall certify compliance with the requirements of 40 CFR 68 as part of the annual compliance certification as required by 40 CFR 70.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

The Permittee shall initiate a permit revision or reopening according to the procedures of 40 CFR 70.7 to incorporate appropriate permit conditions into the Permittee's Part 70 permit.

6. GENERAL TESTING REQUIREMENTS

[COMAR 26.11.01.04]

The Department may require the Permittee to conduct, or have conducted, testing to determine compliance with this Part 70 permit. The Department, at its option, may witness or conduct these tests. This testing shall be done at a reasonable time, and all information gathered during a testing operation shall be provided to the Department.

7. EMISSIONS TEST METHODS

[COMAR 26.11.01.04]

Compliance with the emissions standards and limitations in this Part 70 permit shall be determined by the test methods designated and described below or other test methods submitted to and approved by the Department.

Reference documents of the test methods approved by the Department include the following:

- a. 40 CFR 60, appendix A
- b. 40 CFR 51, appendix M
- c. The Department's Technical Memorandum 91-01 "Test Methods and Equipment Specifications for Stationary Sources", (January 1991), as amended through Supplement 3, (October 1, 1997)

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

8. EMISSIONS CERTIFICATION REPORT

**[COMAR 26.11.01.05-1] and [COMAR 26.11.02.19C] and
[COMAR 26.11.02.19D]**

The Permittee shall certify actual annual emissions of regulated pollutants from the facility on a calendar year basis.

- a. The certification shall be on forms obtained from the Department and submitted to the Department not later than April 1 of the year following the year for which the certification is required;
- b. The individual making the certification shall certify that the information is accurate to the individual's best knowledge. The individual shall be:
 - (1) Familiar with each source for which the certifications forms are submitted, and
 - (2) Responsible for the accuracy of the emissions information;
- c. The Permittee shall maintain records necessary to support the emissions certification including the following information if applicable:
 - (1) The total amount of actual emissions of each regulated pollutant and the total of all regulated pollutants;
 - (2) An explanation of the methods used to quantify the emissions and the operating schedules and production data that were used to determine emissions, including significant assumptions made;
 - (3) Amounts, types and analyses of all fuels used;
 - (4) Emissions data from continuous emissions monitors that are required by this permit, including monitor calibration and malfunction information;
 - (5) Identification, description, and use records of all air pollution control equipment and compliance monitoring equipment including:

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

- (a) Significant maintenance performed,
 - (b) Malfunctions and downtime, and
 - (c) Episodes of reduced efficiency of all equipment;
- (6) Limitations on source operation or any work practice standards that significantly affect emissions; and
- (7) Other relevant information as required by the Department.

9. COMPLIANCE CERTIFICATION REPORT

[COMAR 26.11.03.06G(6) and (7)]

The Permittee shall submit to the Department and EPA Region III a report certifying compliance with each term of this Part 70 permit including each applicable standard, emissions limitation, and work practice for the previous calendar year by April 1 of each year.

- a. The compliance certification shall include:
- (1) The identification of each term or condition of this permit which is the basis of the certification;
 - (2) The compliance status;
 - (3) Whether the compliance was continuous or intermittent;
 - (4) The methods used for determining the compliance status of each source, currently and over the reporting period; and
 - (5) Any other information required to be reported to the Department that is necessary to determine the compliance status of the Permittee with this permit.
- b. The Permittee shall submit the compliance certification reports to the Department and EPA simultaneously.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

10. CERTIFICATION BY RESPONSIBLE OFFICIAL

[COMAR 26.11.02.02F]

All application forms, reports, and compliance certifications submitted pursuant to this permit shall be certified by a responsible official as to truth, accuracy, and completeness. The Permittee shall expeditiously notify the Department of an appointment of a new responsible official.

The certification shall be in the following form:

"I certify under penalty of law that this document and all attachments were prepared under my direction or supervision in accordance with a system designed to assure that qualified personnel properly gather and evaluate the information submitted. Based on my inquiry of the person or persons who manage the system, or those persons directly responsible for gathering the information, the information submitted is, to the best of my knowledge and belief, true, accurate, and complete. I am aware that there are significant penalties for submitting false information, including the possibility of fine and imprisonment for knowing violations."

11. SAMPLING AND EMISSIONS TESTING RECORD KEEPING

[COMAR 26.11.03.06C(5)]

The Permittee shall gather and retain the following information when sampling and testing for compliance demonstrations:

- a. The location as specified in this permit, and the date and time that samples and measurements are taken;
- b. All pertinent operating conditions existing at the time that samples and measurements are taken;
- c. The date that each analysis of a sample or emissions test is performed and the name of the person taking the sample or performing the emissions test;
- d. The identity of the Permittee, individual, or other entity that performed the analysis;
- e. The analytical techniques and methods used; and

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

f. The results of each analysis.

12. GENERAL RECORDKEEPING

[COMAR 26.11.03.06C(6)]

The Permittee shall retain records of all monitoring data and information that support the compliance certification for a period of five (5) years from the date that the monitoring, sample measurement, application, report or emissions test was completed or submitted to the Department.

These records and support information shall include:

- a. All calibration and maintenance records;
- b. All original data collected from continuous monitoring instrumentation;
- c. Records which support the annual emissions certification; and
- d. Copies of all reports required by this permit.

13. GENERAL CONFORMITY

[COMAR 26.11.26.09]

The Permittee shall comply with the general conformity requirements of 40 CFR 93, Subpart B and COMAR 26.11.26.09.

14. ASBESTOS PROVISIONS

[40 CFR 61, Subpart M]

The Permittee shall comply with 40 CFR 61, Subpart M when conducting any renovation or demolition activities at the facility.

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

15. OZONE DEPLETING REGULATIONS

[40 CFR 82, Subpart F]

The Permittee shall comply with the standards for recycling and emissions reduction pursuant to 40 CFR 82, Subpart F, except as provided for MVACs in subpart B:

- a. Persons opening appliances for maintenance, service, repair, or disposal shall comply with the prohibitions and required practices pursuant to 40 CFR 82.154 and 82.156.
- b. Equipment used during the maintenance, service, repair or disposal of appliances shall comply with the standards for recycling and recovery equipment pursuant to 40 CFR 82.158.
- c. Persons performing maintenance, service, repairs or disposal of appliances shall be certified by an approved technician certification program pursuant to 40 CFR 82.161.
- d. Persons disposing of small appliances, MVACS, and MVAC-like appliances as defined in 40 CFR 82.152, shall comply with record keeping requirements pursuant to 40 CFR 82.155.
- e. Persons owning commercial or industrial process refrigeration equipment shall comply with the leak repair requirements pursuant to 40 CFR 82.156.
- f. Owners/operators of appliances normally containing 50 or more pounds of refrigerant shall keep records of refrigerant purchased and added to such appliances pursuant to 40 CFR 82.166.

16. ACID RAIN PERMIT

Not applicable

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

SECTION IV PLANT SPECIFIC CONDITIONS

This section provides tables that include the emissions standards, emissions limitations, and work practices applicable to each emissions unit located at this facility. The Permittee shall comply with all applicable emissions standards, emissions limitations and work practices included herein.

The tables also include testing, monitoring, record keeping and reporting requirements specific to each emissions unit. In addition to the requirements included here in **Section IV**, the Permittee is also subject to the general testing, monitoring, record keeping, and reporting requirements included in **Section III – Plant Wide Conditions** of this permit.

Unless otherwise provided in the specific requirements for an emissions unit, the Permittee shall maintain at the facility for at least five (5) years, and shall make available to the Department upon request, all records that the Permittee is required under this section to establish. [Reference: **COMAR 26.11.03.06C(5)(g)**]

Table IV – 1	
1.0	<p><u>Emissions Unit Number(s): C1, C2, C3, & C4</u></p> <p><u>Fuel burning equipment.</u></p> <p>C1 thru C4: Four (4) Combustion Engineering Boilers each rated at 130 MMBtu/hr. firing natural gas and fuel oil (No. 2 or No. 6) (only during periods of natural gas curtailment), and each equipped with an ultra-low NO_x burner. [MDE Reg. Nos. 510-0314-5-1444, 5-1445, 5-1446, and 5-1447].</p>
1.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.09.05A - Visible Emissions. (2) "Areas III and IV. In Areas III and IV, a person may not cause or permit the discharge of emissions from any fuel burning equipment, other than water in an uncombined form, which is visible to human observers except that, for the purpose of demonstrating compliance using COM data, emissions that are visible to a human observer are those that are equal to or greater than 10 percent opacity.</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1

(3) Exceptions. Section A(1) and (2) of this regulation do not apply to emissions during load changing, soot blowing, startup, or adjustments or occasional cleaning of control equipment if:

(a) The visible emissions are not greater than 40 percent opacity; and

(b) The visible emissions do not occur for more than 6 consecutive minutes in any sixty-minute period.”

B. Control of Particulate Matter

(1) **COMAR 26.11.09.06B(1)(a) - Control of Particulate Matter - Areas III and IV – Dust Collector Devices Required.** “A person may not cause or permit the combustion of residual fuel oil in fuel burning equipment unless the equipment is fitted with a dust collector which is so designed that it can reasonably be expected to produce sufficient dust particle force, residence time, and particle retention to satisfy the requirements of Table 1. This paragraph does not apply to fuel burning equipment where by-product gases or by-product gases in combination with residual fuel oil are burned and where the effluent gases do not contain particulate matter in excess of the requirements of Table 1, as applicable to residual oil burning.”

(2) **COMAR 26.11.09.06B(2) - Control of Particulate Matter - Areas III and IV - Residual Fuel-Oil-Burning Equipment.** “A person may **not** cause or permit particulate matter caused by the combustion of residual fuel oil to be discharged into the atmosphere in excess of the amounts shown in Table 1.”

(3) **COMAR 26.11.09.09: Table 1 - Emission Standards and Dust Collector Performance Standards for Fuel-Burning Equipment.**

Table 1		
Emission Standards and Dust Collector Performance Standards for Fuel-Burning Equipment		
<i>Equipment Description</i>	<i>Max. Rated Heat Input in million Btu (gigajoules) per hour per furnace</i>	<i>Max. Allowable Emissions of Part. Matter – gr/scfd (mg/dscm)</i>
Existing and new equipment burning residual oil	Less than 13 (13.7) 13 – 50 (13.7 – 52.8) 50 – 250 (52.8 – 265)	No requirement (a) 0.03 (69) 0.020 (46)

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 1

(4) No. 6 fuel oil is limited to a maximum of 0.068% ash content.
[Reference: MDE letter dated November 8, 2005 & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

C. Control of Sulfur Oxides

(1) **COMAR 26.11.09.07A(2) - Sulfur Content Limitations for Fuel.**

"A person may not burn, sell, or make available for sale any fuel with a sulfur content by weight in excess of or which otherwise exceeds the following limitations: (2) In Areas III and IV:

- (a) *Not applicable.*
- (b) Distillate fuel oils, 0.3 percent.
- (c) Residual fuel oils, 1.0 percent."

(2) No. 6 fuel oil is limited to a maximum of 0.5% sulfur content.
[Reference: MDE letter dated November 8, 2005 & MDE Permit to Construct 510-5-1444 through 5-1447 issued on August 28, 2014]

D. Control of Nitrogen Oxides

(1) **COMAR 26.11.09.08B(1)(c) - Control of NO_x for Major Stationary Sources – Emissions Standards and Requirements.**

"Emission Standards in Pounds of NO_x per Million Btu of heat input."

Fuel	Tangential Fired	Wall-Fired
Gas only	0.20	0.20
Gas/Oil	0.25	0.25
Coal (dry bottom)	0.38	0.38
Coal (wet bottom)	1.00	1.00

(2) **COMAR 26.11.09.08B(5) - Control of NO_x for Major Stationary Sources – Operator Training.**

- (a) "For purposes of this regulation, the equipment operator to be trained may be the person who maintains the equipment and makes the necessary adjustments for efficient operation.
- (b) The operator training course sponsored by the Department shall include an in-house training course that is approved by the Department."

(3) **COMAR 26.11.09.08D(1)(b) - Requirements for Fuel-Burning Equipment with a Rated Heat Input Capacity of Less than 250 Million Btu Per Hour and Greater than 100 Million Btu Per Hour.**

"All other fuel burning equipment with a rated heat input capacity of

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 1

less than 250 Million Btu per hour and greater than 100 Million Btu per hour shall meet the NO_x emission rates set forth in §B(1)(c) of this regulation.”

(4) No. 6 fuel oil is limited to a maximum of 0.5% nitrogen content. **[Reference: MDE letter dated November 8, 2005 & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

E. Operational Limitations

(1) The Permittee shall operate the boilers such that the combined hours of operation for Boilers #1 through #4 do not exceed 20,220 hours in any consecutive 12-month period. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(12) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(2) In accordance with COMAR 26.11.09.06B(2), particulate matter emissions from the stack services Boilers #1 through #4 shall not exceed 0.020 grains per SCFD (corrected to 50% excess oxygen). **[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(3) In order to meet the 0.020 grains per SCFD (corrected to 50% excess oxygen) particulate matter emissions limit of COMAR 26.11.09.06B(2), the Permittee shall:

(a) Use only fuel oil (No. 2 or No. 6) in Boilers #1 through #4 with an ash content weight percent that will not cause total particulate matter emissions from the single powerhouse stack to exceed 0.020 grains per SCFD (corrected to 50% excess oxygen);

(b) Use natural gas and fuel oil (No. 2 or No. 6) in separate operating boilers that will not cause total particulate matter emissions from the single powerhouse stack to exceed 0.020 grains per SCFD (corrected to 50% excess oxygen); or

(c) Install a dust collector device designed to meet the 0.020 grains per SCFD (corrected to 50% excess oxygen) particulate matter emissions limit per COMAR 26.11.09.06B(1)(a).

[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

(4) The Permittee shall design and operate the ultra-low NO_x burners on Boilers 1-4 and the low NO_x burner on Boiler 6 to meet the emission rate of 500 lbs./day (or 624 lbs./day, when appropriate) on a 30-day rolling average. **[Reference: District**

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1

Court Consent Decree, Civil Action No. JKB-12-1408, Sections V(11)(a) & V(10)(d) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014 and approved by the EPA in a letter on April 2, 2014.]

(5) The primary combined NO_x emission limit that applies to the operation of boilers 1-4 and 6 is 500 lbs./day, calculated on a 30-day rolling average as described in the Order Modifying Consent Decree. This limit applies at all times, except in the circumstances described below when the limit of 624 lbs./day applies.

(a) Any day in which:

- i. Boiler 6 operates at any point in time;
- ii. Boiler 6 operates in conjunction with any of the CE boilers; or
- iii. Boiler 6 does not operate and only three (3) of the CE boilers operate would count toward the 500 lbs./day 30 day rolling average.

(b) If there are seven calendar days within a 30-day period in which Boiler 6 does not operate and each of the four CE boilers operates for some period of time in that calendar day, then the combined NO_x emission limit is 624 lbs./day. The seven days do not need to be consecutive.

(c) ASR will calculate the 30-day rolling average each day. If all four CE boilers operated for six days or less within the previous 30 calendar day period, the limit of 500 lbs./day applies. If all four CE boilers operated seven days or more during the previous 30-calendar day period, the limit of 624 lbs./day applies.

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(a) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]

(6) The Permittee shall continuously operate the NO_x control technology at all times of boiler operation. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(b) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1

	<p>(7) The total combined NO_x emissions from Boilers 1-4 & 6 in any consecutive 12-month period shall not exceed 60 tons. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(13) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014 and approved by the EPA in a letter on April 2, 2014.]</p> <p>(8) The total combined NO_x emissions from Boilers 1-4 & 6 in any calendar month shall not exceed 6.0 tons. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(14) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]</p>
<p>1.2</p>	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall conduct Method 9, 22 or equivalent method approved by the Department opacity observations for at least one hour during stack testing to demonstrate compliance with the no visible emissions requirement of COMAR 26.11.09.05A(2) when burning fuel oil (No. 2 or No. 6). [Reference: COMAR 26.11.03.06C & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]</p> <p>B. <u>Control of Particulate Matter</u> Stack emissions tests shall be conducted at least once every two-year period to demonstrate compliance with the 0.020 gr/scfd particulate matter emission limit when the boiler burns fuel oil (No. 2 or No. 6) with a pre-determined ash content weight percent. Stack emissions tests shall be conducted to demonstrate compliance with the 0.020 gr/scfd particulate matter emission limit can be achieved during either of the following operating conditions: (1) Burning only fuel oil (No. 2 or No. 6) with a pre-determined ash content weight percent in boilers 1 thru 4; and burning the lowest possible ratio of natural gas to fuel oil (No. 2 or No. 6) in boilers #1 thru #4. (2) Boilers #1 thru #4 shall each be operated at 90% or higher of their rated capacity during all stack emissions tests. [Reference: COMAR 26.11.03.06C]</p> <p><u>Note:</u> The Permittee is not required to conduct stack testing on Boilers #1 thru #4 when fuel oil (No. 2 or No. 6) has not been utilized at any time during the preceding two (2) years.</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1	
	<p>C. <u>Control of Sulfur Oxides</u> See Monitoring Requirements.</p> <p>D. <u>Control of Nitrogen Oxides</u> See Monitoring Requirements.</p> <p>E. <u>Operational Limitations</u> See Monitoring Requirements.</p>
1.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall: (1) properly operate and maintain the boilers in a manner to prevent visible emissions; and (2) verify no visible emissions when burning fuel oil (No. 2 or No. 6). The Permittee shall perform a visual observation for a 6-minute once for each 168-hour period when the boiler burns fuel oil. If a boiler does not burn fuel oil for more than 100 hours in a calendar year, the visible emission observation requirement is waived for that boiler. (3) The Permittee shall perform the following if visible emissions are observed: (a) inspect combustion system and boiler operation; (b) perform all necessary adjustments and/or repairs to the boiler within 48 hours so that visible emissions are eliminated; (c) document in writing the results of inspections, adjustments, and/or repair to the boiler; and (d) after 48 hours, if required adjustments and/or repair had not eliminated the visible emissions, perform a Method 9 observation for an 18-minute period once per day until corrective actions have eliminated the visible emissions. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the fuel oil (No. 2 or No. 6) has an ash content equal to or less than 0.068% by weight. [Reference: MDE letter dated November 8, 2005 & COMAR 26.11.03.06C]</p> <p>C. <u>Control of Sulfur Oxides</u> (1) The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the No. 6 fuel oil has a sulfur content equal to or less than 0.5% by weight. [Reference: MDE letter dated November 8, 2005 & COMAR 26.11.03.06C]</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1

(2) The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the No. 2 fuel oil has a sulfur content equal to or less than 0.3% by weight. **[Reference: COMAR 26.11.03.06C]**

D. Control of Nitrogen Oxides

(1) The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the oil has a nitrogen content equal to or less than 0.5% by weight. **[Reference: MDE letter dated November 8, 2005 & COMAR 26.11.03.06C]**

(2) At a point in each stack prior to a point at which boiler flue gas combines with flue gas from any other boiler, the Permittee shall install and make operational, concurrent with commencement of operations of the ultra-low NO_x burners, an NO_x continuous emissions monitoring system (CEMS) to monitor NO_x emissions in accordance with the requirements of 40 CFR Part 60. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(15) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(3) The required CEMS shall monitor and record the applicable NO_x Emission Rate for each boiler to demonstrate compliance with the established NO_x Emissions Rates and shall be continuously operated, except during CEMS breakdowns, repairs, calibration checks, and zero span adjustments. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(16) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(4) If the Permittee is unable to obtain emissions data from the CEMS because of a malfunction of the CEM for more than 2 hours in duration, the Permittee shall use the alternative measurement method approved by the Department and EPA. **[Reference: COMAR 26.11.01.11B(4) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(5) A CEMS used to monitor a gas concentration shall record not less than four equally spaced data points per hour and automatically reduce data in terms of averaging times consistent with the applicable emission standard per COMAR 26.11.01.11D. **[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(6) All emissions of NO_x shall be measured by the CEMS. During any periods of time when any CEMS is inoperable or not measuring NO_x

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1

	<p>emissions from any boiler, the Permittee shall apply the missing data substitution procedures provided in 40 CFR Part 75, Subpart D. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(18) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]</p> <p>(7) COMAR 26.11.01.11C – <u>Quality Assurance for CEMS.</u> "A CEM used to monitor a gas concentration shall meet the quality assurance criteria of 40 CFR Part 60, Appendix F, as amended, which is incorporated by reference, or, if applicable, the quality assurance criteria of 40 CFR Part 75, Appendix B, as amended."</p> <p>E. <u>Operational Limitations</u> See Monitoring Requirements for Control of Nitrogen Oxides.</p>
<p>1.4</p>	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall: (1) maintain an operational manual and preventive maintenance plan on site; (2) maintain the test result of the Method 9 performed; (3) maintain records of the results of the monthly inspections; (4) maintain a record of the maintenance performed that relates to combustion performance; (5) maintain a log of visible emissions observations performed and make it available to the Department upon request; (6) maintain a record of the hours that fuel oil (No. 2 or No. 6) is burned. [Reference: COMAR 26.11.03.06C].</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall: (1) maintain records of all stack emissions test documents and (2) maintain the fuel supplier certification for each shipment of fuel oil (No. 2 or No. 6) stating the ash content in weight percent. [Reference: COMAR 26.11.03.06C]</p> <p>C. <u>Control of Sulfur Oxides</u> The Permittee shall maintain records of the annual fuel supplier certifications stating that the No. 6 fuel oil used in Boilers #1 thru #4 is in compliance with the 1.0% by weight sulfur limitation required by COMAR</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1

26.11.09.07A(2)(c). **[Note: Per November 8, 2005, letter from MDE, based on stack testing data, sulfur content of fuel oil is not to exceed 0.5%]**

The Permittee shall maintain records of the annual fuel supplier certifications stating that the No. 2 fuel oil used in Boilers 1 thru 4 is in compliance with the 0.3% by weight sulfur limitation required by COMAR 26.11.09.07A(2)(b).

The Permittee shall maintain records of the certification from the supply company of all natural gas curtailment events, including date and duration of the event.

[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

D. Control of Nitrogen Oxides

The Permittee shall maintain records of the following and make available to the Department upon request:

- (1) The fuel supplier certification for each shipment of fuel oil (No. 2 or No. 6) stating the nitrogen content in weight percent.
- (2) All training and combustion analysis records required by COMAR 26.11.09.08B(5).

[Reference: COMAR 26.11.03.06C]

E. Operational Limitations

(1) The Permittee shall maintain electronically for at least five (5) years, and shall make available to the Department upon request, records of the following information:

- (a) Monthly fuel oil (No. 2 or No. 6) usage in gallons per month and the total fuel usage (No. 2 or No. 6) for the previous rolling 12-month period. **[Reference: MDE Permit to Construct 510-5-1444 through 5-1447(August 28, 2014)]**
- (b) To comply with the annual emissions cap - the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the total amount of NO_x emissions for the current month and the previous eleven months. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(20) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**
- (c) To comply with the monthly emissions cap - the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the amount of NO_x emissions for each operating day during the month. **[Reference: District Court Consent Decree, Civil**

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1	
	<p>Action No. JKB-12-1408, Section V(21) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)] (d) All stack emissions test documents. [Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]</p> <p>(2) To comply with the limit on combined total hours of operation for Boilers #1 through #4, the Permittee shall maintain electronically for at least five (5) years, and shall make available to the Department upon request, monitoring records of the hours of operation of each boiler. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(19) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]</p>
1.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall report, in accordance with requirements under COMAR 26.11.01.07, occurrences of excess emissions to the Compliance Program of the Air and Radiation Administration.</p> <p>B. <u>Control of Particulate Matter</u> (1) At least 30 days prior to the projected date of the stack emission test, the Permittee shall submit a test protocol to the Department for review and approval. (2) Within 45 days after the emission test, the Permittee shall submit to the Department a stack test report that includes the stack emissions test results and opacity observations results. [Reference: COMAR 26.11.03.06C]</p> <p>C. <u>Control of Sulfur Oxides</u> The Permittee shall make records of certification from the supplier available to the Department upon request. [Reference: COMAR 26.11.03.06C]</p> <p>D. <u>Control of Nitrogen Oxides</u> (1) The Permittee shall submit a record of training program attendance for each operator to the Department upon request. (2) The Permittee shall comply with the CEM System Downtime Reporting Requirements of COMAR 26.11.01.11E as follows: (a) All CEM system downtime that lasts or is expected to last more than 24 hours shall be reported to the Department by telephone before 10 a.m. of the first regular business day following the breakdown.</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 1

(b) The system breakdown report required by §E(1)(a) of this regulation shall include the reason, if known, for the breakdown and the estimated period of time that the CEM will be down. The owner or operator of the CEM shall notify the Department by telephone when an out-of-service CEM is back in operation and producing data that has met performance specifications for accuracy, reliability, and durability of acceptable monitoring systems, as provided in COMAR 26.11.31, and is producing data.

(3) The Permittee shall comply with the CEM Data Reporting Requirements of COMAR 26.11.01.11E as follows:

(a) All test results shall be reported in a format approved by the Department.

(b) Certification testing shall be repeated when the Department determines that the CEM data may not meet performance specifications because of component replacement or other conditions that affect the quality of generated data.

(c) A quarterly summary report shall be submitted to the Department not later than 30 days following each calendar quarter. The report shall be in a format approved by the Department, and shall include the following:

(i) The cause, time periods, and magnitude of all emissions which exceed the applicable emission standards;

(ii) The source downtime including the time and date of the beginning and end of each downtime period and whether the source downtime was planned or unplanned;

(iii) The time periods and cause of all CEM downtime including records of any repairs, adjustments, or maintenance that may affect the ability of the CEM to meet performance specifications of emission data;

(iv) Quarterly totals of excess emissions, installation downtime, and CEM downtime during the calendar quarter;

(v) Quarterly quality assurance activities;

(vi) Daily calibration activities that include reference values, actual values, absolute or percent of span differences, and drift status; and

(vii) Other information required by the Department that is determined to be necessary to evaluate the data, to ensure that compliance is achieved, or to determine the applicability of this regulation.

(d) All information required by this regulation to be reported to the Department shall be retained and made available for review by the Department for a minimum of 2 years from the time the report is submitted."

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 1	
	<p>(4) The Permittee must report orally or by electronic or facsimile transmission to the U.S. EPA and MDE, no later than 24 hours after the Permittee knew or should have known of any violation of the District Court Consent Decree, any permit regulations, or any event that may pose an immediate threat to the public health or welfare or the environment.</p> <p>(5) The Permittee shall submit within 30 days following each January 1st and July 1st a semi-annual report to the U.S. EPA for the immediately preceding half-calendar year period. This report shall:</p> <p>(a) Identify any and all dates on which the Permittee has installed, or describe the progress of installation of, each ultra-low NO_x burner required for NO_x control, emission limits, CEMS, and monitoring requirements, and describe any problems encountered or anticipated during such installation, together with implemented or proposed solutions;</p> <p>(b) Provide all CEMS data collected for each Boiler #1 through #4 including an explanation of any periods of CEMS downtime together with any missing data for which American Sugar applied missing data substitution procedures, under Section VI.B of the Consent Order.</p> <p>(c) Demonstrate compliance with all applicable 30-day rolling average emission limits in Section V of the District Court Consent Decree.</p> <p>(d) Describe the status of any operation and maintenance work relating to activities required under the District Court Consent Decree.</p> <p>[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]</p> <p>E. <u>Operational Limitations</u> See Reporting Requirements for Control Nitrogen Oxides.</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 2	
2.0	<p><u>Emissions Unit Number(s): C6</u></p> <p><u>Fuel burning equipment.</u></p> <p>C6 – One (1) Babcock and Wilcox boiler rated at 300 MMBtu/hr. firing natural gas and equipped with a low NO_x burner and flue gas recirculation. (MDE Reg. No. 510-0314-5-1476)</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 2

2.1 Applicable Standards/Limits:

A. Control of Visible Emissions

COMAR 26.11.09.05A - Visible Emissions

“(2) Areas III and IV. In Areas III and IV, a person may not cause or permit the discharge of emissions from any fuel burning equipment, other than water in an uncombined form, which is visible to human observers except that, for the purpose of demonstrating compliance using COM data, emissions that are visible to a human observer are those that are equal to or greater than 10 percent opacity.

(3) Exceptions. “Section A(1) and (2) of this **regulation** do not apply to emissions during load changing, soot blowing, startup, or adjustments or occasional cleaning of control equipment if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any sixty-minute period.”

B. Control of Nitrogen Oxides

(1) **COMAR 26.11.09.08B(1)(a), Control of NO_x Emissions for Major Stationary Sources - General Requirements and Conditions.** “Emission Standards and Requirements. A person who owns or operates an installation that causes NO_x emissions subject to this regulation is in compliance with this regulation if the person establishes compliance with the emissions standards in §B(1)(c) of this regulation.”

(2) **COMAR 26.11.09.08B(1)(c), Control of NO_x Emissions for Major Stationary Sources – General Requirements and Conditions.** “Emission Standards in Pounds of NO_x per Million Btu of heat input.”

Fuel	Tangential- Fired	Wall-Fired
Gas only	0.20	0.20
Gas/Oil	0.25	0.25
Coal (dry bottom)	0.38	0.38
(3) Coal (wet bottom)	1.00	1.0

COMAR 26.11.09.08B(2)(a)(i) and (b), (c), and (d), **Control of NO_x Emissions for Major Stationary Sources – Demonstration of Compliance.**

(a) “A person subject to a NO_x emission standard in this regulation shall demonstrate compliance as follows:

- (i) For installations equipped with a CEM, compliance with the NO_x emissions standards in this regulation shall be established using CEM data; or”
- (ii) *Not applicable.*

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 2

(b) "CEMs shall be certified in accordance with 40 CFR Part 60, Appendix B, or Part 75, Appendix A."

(c) "CEMs shall meet the quality assurance criteria in 40 CFR Part 60, Appendix F, or, for sources subject to Title IV of the Clean Air Act (Acid Rain), the quality assurance criteria in 40 CFR Part 75, Appendix B."

(d) "Except as otherwise established by the Department and approved by the EPA, for a person who establishes compliance with the NO_x emissions standards in this regulation using a CEM, compliance shall be determined as 30-day rolling averages."

(e) *Not applicable.*

(4) **COMAR 26.11.09.08B(5) - Operator Training.**

(a) "For purposes of this regulation, the equipment operator to be trained may be the person who maintains the equipment and makes the necessary adjustments for efficient operation.

(b) The operator training course sponsored by the Department shall include an in-house training course that is approved by the Department."

(5) **COMAR 26.11.09.08C(3), Requirements for Fuel-Burning Equipment with a Rated Heat Input Capacity of 250 Million Btu Per Hour or Greater.**

"A person who owns or operates fuel burning equipment with a rated heat input capacity of 250 Million Btu per hour or greater shall install, operate, calibrate, and maintain a certified NO_x CEM or an alternative NO_x monitoring method approved by the Department and the EPA on each installation."

(6) The Permittee shall design and operate the ultra-low NO_x burners on Boilers 1-4 and the low NO_x burner on Boiler 6 to meet the emission rate of 500 lbs./day (or 624 lbs./day, when appropriate) on a 30-day rolling average. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Sections V(11)(a) & V(10)(d) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014 and approved by the EPA in a letter on April 2, 2014.]

(7) The primary combined NO_x emission limit that applies to the operation of boilers 1-4 and 6 is 500 lbs./day, calculated on a 30-day rolling average as described in the District Court Consent Decree. This limit applies at all times, except in the circumstances described below when the limit of 624 lbs./day applies.

(a) Any day in which:

(1) Boiler #6 operates at any point in time;

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 2

(2) Boiler #6 operates in conjunction with any of the CE boilers; or
(3) Boiler #6 does not operate and only three (3) of the CE boilers operate would count toward the 500 lbs./day 30 day rolling average.

(b) If there are seven calendar days within a 30-day period in which Boiler #6 does not operate and each of the four CE boilers operates for some period of time in that calendar day, then the combined NO_x emission limit is 624 lbs./day. The seven days do not need to be consecutive.

(c) ASR will calculate the 30-rolling average each day. If all four CE boilers operated for six days or less within the previous 30 calendar day period, the limit of 500 lbs./day applies. If all four CE boilers operated seven days or more during the previous 30-calendar day period, the limit of 624 lbs./day applies.

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(a) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]

(8) The total combined NO_x emissions from Boilers #1-#4 & #6 in any consecutive 12-month period shall not exceed 60 tons. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(13) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014 and approved by the EPA in a letter on April 2, 2014.]**

(9) The total combined NO_x emissions from Boilers #1-#4 & 6 in any calendar month shall not exceed 6.0 tons. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(14) & MDE Permit to Construct 510-5-1476 (August 28, 2014)]**

(10) The Permittee shall not cause to be discharged into the atmosphere any gases that contain NO_x (expressed as NO₂) in excess of 86 ng/J (0.20 lb./MMBtu) heat input. This limit applies at all times including periods of startup, shutdown, or malfunction. Compliance with this emission limit is determined on a 30-day rolling average basis.

[Reference: 40 CFR §60.44b(l)(1), 40 CFR §60.44b(h), 40 CFR §60.44b(i), and 40 CFR §60.46b(a) & MDE Permit to Construct 510-5-1476 (August 28, 2014)]

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 2

(11) The Permittee shall continuously operate the low NO_x burner at all times of boiler operation. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(b) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]

(12) COMAR 26.11.40-NO_x Ozone Season Emission Caps for Non-trading Large NO_x Units.

.02 Applicability.

“A. The owner or operator of a non-trading large NO_x unit, that is not a unit subject to the federal Cross State Air Pollution Rule NO_x Ozone Season Group 2 Trading Program established under 40 CFR Part 97, Subpart EEEEE, shall comply with the ozone season NO_x emission limitation, monitoring, record keeping, and reporting requirements for ozone season emissions of NO_x set forth in this chapter. *(This is superseded by Group 3 Subpart GGGGG published April 30, 2021, effective June 29, 2021).*

B. The requirements of this chapter apply to a person who owns or operates a non-trading large NO_x unit located at the affected sources in §C of this regulation.

C. Affected Sources and Units. (1) American Sugar Unit No. C6.”

.03 NO_x Ozone Season Emission Caps.

A. The total combined NO_x ozone season emissions for all non-trading large NO_x units subject to this chapter may not exceed 1013 tons in accordance with the 40 CFR Part 97, Subpart E, Appendix C.

B. NO_x Ozone Season Emission Caps.

(1) The total combined ozone season NO_x emissions from all the affected units at an affected source as identified in Regulation .02C of this chapter may not exceed the NO_x ozone season emission caps in §B(2) of this regulation.

(2) Table – NO_x Ozone Season Emission Caps.

Affected Sources	NO _x Ozone Season Emission Caps Beginning May 1, 2018
American Sugar	24 tons

C. Operational Limitations

(1) The Permittee shall burn only natural gas in this boiler. [Reference: MDE Permit to Construct 510-5-1476 (August 28, 2014)]

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 2	
	<p>(2) The Permittee must use gaseous fuels with potential SO₂ emissions rates of 26 ng/J (0.060 lb./MMBtu) or less and shall not use post-combustion technology to reduce SO₂ or PM emissions. The Permittee must meet these requirements in order to not be required to install or operate a COMS. [Reference: 40 CFR §60.48b(j)(2) & MDE Permit to Construct 510-5-1476 (August 28, 2014)]</p>
2.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Reporting Requirements.</p> <p>B. <u>Control of Nitrogen Oxides</u> (1) The Permittee shall conduct the performance test as required under §60.8 using the continuous system for monitoring NO_x under §60.48b to determine compliance with the NO_x emission limit as follows: Following the date on which the initial performance test is completed or is required to be completed under §60.8, whichever date comes first, the Permittee shall determine compliance with the NO_x standards under §60.44b on a continuous basis through the use of a 30-day rolling average emission rate. A new 30-day rolling average emission rate is calculated each steam generating unit operating day as the average of all of the hourly NO_x emission data for the preceding 30 steam generating unit operating days. (2) Repeat certification testing when the Department determines that the CEM data may not meet performance specifications because of component replacement or other conditions that affect the opacity of generated data. [Reference: 40 CFR §60.46b(c) and 40 CFR §60.46b(e)(1) and (3) & COMAR 26.11.01.11E(2)(b)]</p> <p>C. <u>Operational Limitations</u> See Monitoring Requirements.</p>
2.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Reporting Requirements.</p> <p>B. <u>Control of Nitrogen Oxides</u> (1) At a point in the stack prior to a point at which boiler flue gas combines with flue gas from any other boiler, American Sugar shall install and make operational, a NO_x continuous emissions monitoring system (CEMS) to</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 2

monitor NO_x emissions in accordance with the requirements of 40 CFR Part 60. The CEMS shall be installed and operated in accordance with the plan approved by the Department and EPA under the provisions of COMAR 26.11.01.11B(1)(a).

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(15) and COMAR 26.11.01.11B(1)(a) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014) & COMAR 26.11.40.04A(1)]

(2) The Permittee shall calibrate, maintain, and operate a continuous emissions monitoring system, and record the output of the system for measuring NO_x emissions in accordance with 40 CFR §60.48b(b)(1).

(3) Each CEMs shall be installed, certified, calibrated, maintained, and operated in accordance with the applicable requirements of 40 CFR Part 60, and any requirements established by applicable Maryland regulations. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(17) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(4) The Permittee shall install, calibrate, maintain, and operate CEMS for measuring NO_x and O₂ (or CO₂) emissions discharged to the atmosphere, and shall record the output of the system. **[Reference: 40 CFR §60.48b(b)(1)]**

(5) The procedures under §60.13 shall be followed for installation, evaluation, and operation of the continuous monitoring system. The span value for NO_x is 500 ppm. **[Reference: 40 CFR §60.48b(e)(2)(i)]**

(6) The CEMS shall monitor and record the applicable NO_x Emission Rate for Boiler #6 to demonstrate compliance with the NO_x emission rates and shall be continuously operated, except during CEMS breakdowns, repairs, calibration checks, and zero span adjustments. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(16) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(7) The CEMS shall be operated, and data recorded during all periods of operation of Boiler #6 except for CEMS breakdowns and repairs. Data is recorded during calibration checks, and zero and span adjustments. **[Reference: 40 CFR §60.48b(c)]**

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 2

(8) The Permittee shall measure all emissions of NO_x with the CEMS. During any period of time when any CEMS is inoperable or not measuring NO_x emissions from Boiler #6, the Permittee shall apply the missing data substitution procedures in 40 CFR Part 75, Subpart D. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(18) and 40 CFR §60.48b(f) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(9) To comply with the annual emission cap, the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the total amount of NO_x emissions for the current month and the previous eleven months. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(20) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(10) To comply with the monthly emissions cap, the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the amount of NO_x emissions for each Operating Day during the month. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(21) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(11) The 1-hour average NO_x emission rates measured by the continuous NO_x monitor required by 40 CFR §60.48b(b) and required under §60.13(h) shall be expressed in ng/J or lb./MMBtu heat input and shall be used to calculate the average emission rates under §60.44b. The 1-hour averages shall be calculated using the data points required under §60.13(h)(2). **[Reference: 40 CFR §60.48b(d)]**

(12) The Permittee shall use the alternative measurement method approved by the Department and the EPA if the Permittee is unable to obtain emissions data from CEMS because of a malfunction of the CEMS for more than 2 hours in duration. **[Reference: COMAR 26.11.01.11B(4)]**

(13) The Permittee shall ensure that the CEMS used to monitor a gas concentration shall meet the quality assurance criteria of 40 CFR Part 60, Appendix F, as amended, which is incorporated by reference, or, if applicable, the quality assurance criteria of 40 CFR Part 75, Appendix B, as amended. **[Reference: COMAR 26.11.01.10C]**

(14) The CEM used to monitor a gas concentration shall record not less than four equally spaced data points per hour and automatically reduce

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 2	
	<p>data in terms of averaging times consistent with the applicable emission standard. [Reference: COMAR 26.11.01.11D(2)]</p> <p>C. <u>Operational Limitations</u> The Permittee shall install meters to record the hours of operation of this boiler and shall maintain the monitoring records in an electronic format for at least five (5) years. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(19) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]</p>
2.4	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> See Reporting Requirements.</p> <p>B. <u>Control of Nitrogen Oxides</u> The Permittee shall maintain records for at least two (2) years of the following information for Boiler 6 for each operating day.</p> <ul style="list-style-type: none"> (a) Calendar date; (b) The average hourly NO_x emission rates (expressed as NO₂) (ng/J) or lb./MMBtu heat input) measured or predicted; (c) The 30-day average NO_x emission rates (ng/J or lb./MMBtu heat input) calculated at the end of each Boiler #6 operating day from the measured or predicted hourly nitrogen oxide emission rates for the preceding 30 Boiler 6 operating days; (d) Identification of the Boiler 6 operating days when the calculated 30-day average NO_x emission rates are in excess of the NO_x emissions standards under §60.44b, with the reasons for such excess emissions as well as a description of corrective actions taken; (e) Identification of the Boiler 6 operating days for which pollutant data have not been obtained, including reasons for not obtaining sufficient data and a description of corrective actions taken; (f) Identification of the times when emission data have been excluded from the calculation of average emission rates and the reasons for excluding data; (g) Identification of the “F” factor used for calculations, method of determination, and type of fuel combusted; (h) Identification of the times when the pollutant concentration exceeded full span of the CEMS;

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 2	
	<p>(i) Description of any modifications to the CEMS that could affect the ability of the CEMS to comply with Performance Specification 2 or 3 in appendix B of 40 CFR Part 60; and</p> <p>(j) Results of daily CEMS drift tests and quarterly accuracy assessments as required under appendix F, Procedure 1 of 40 CFR Part 60. [Reference: 40 CFR §60.49b(g), (i) and (o) & COMAR 26.11.40.04A(2)]</p> <p>The Permittee shall maintain for at least five (5) years, and shall make available to the Department upon request, records of the following information:</p> <p>(a) Annual fuel use records for Boiler #6;</p> <p>(b) Log of operation and maintenance of the CEMs including duration and reason of any malfunctions; and</p> <p>(c) Records of operator training. [Reference: MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]</p> <p><u>C. Operational Limitations</u> The Permittee shall record and maintain records of the amounts of natural gas combusted during each day and calculate the annual capacity factor for natural gas for the reporting period. The annual capacity factor is determined on a 12-month rolling average basis with a new annual capacity factor calculated at the end of each calendar month. The records must be maintained on-site for at least two (2) years and be made available to the Department upon request. [Reference: 40 CFR §60.49b(d)(1) and (o)]</p>
2.5	<p><u>Reporting Requirements:</u></p> <p><u>A. Control of Visible Emissions</u> The Permittee shall report, in accordance with requirements under COMAR 26.11.01.07, occurrences of excess emissions to the Compliance Program of the Air and Radiation Administration.</p> <p><u>B. Control of Nitrogen Oxides</u> (1) The Permittee must submit excess emission reports for any excess emissions that occurred during the reporting period. The Permittee must maintain these records on site for at least two (2) years. [Reference: 40 CFR §60.49b(h)(2)(i) and (o)]</p> <p>(2) The Permittee must report orally or by electronic or facsimile transmission to the U.S. EPA and MDE, no later than 24 hours after the Permittee knew or should have known of any violation of the District Court</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 2

Consent Decree, any permit regulations, or any event that may pose an immediate threat to the public health or welfare of the environment.
[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section IX(40) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]

(3) **COMAR 26.11.09.08K - Reporting Requirements.**

- (a) "When demonstration of compliance with the NO_x emission standards in this regulation is based on CEM data, quarterly emission reports shall be submitted to the Department on or before the thirtieth day of the month following the end of each calendar quarter.
- (b) When compliance with this regulation is demonstrated by a stack test, the results of the stack tests required by this regulation shall be submitted to the Department within 45 days after completion of the test.
- (c) A person subject to this regulation shall maintain annual fuel use records on site for not less than 3 years and make these records available to the Department upon request."

(4) The Permittee must report to the Department, by telephone, any CEM system downtime that lasts or is expected to last more than 24 hours, by 10 a.m. of the first regular business day following the breakdown. The Permittee must also notify the Department, by telephone, when an out-of-service CEMS is back in operation. **[Reference: COMAR 26.11.01.11E(1)(a) and (b)]**

(5) The Permittee shall comply with the CEM system downtime reporting requirements of COMAR 26.11.01.11E:

- (a) All CEM system downtime that lasts or is expected to last more than 24 hours shall be reported to the Department by telephone before 10 a.m. of the first regular business day following the breakdown.
- (b) The system breakdown report required by COMAR 26.11.01.11E(1)(a) shall include the reasons, if known, for the breakdown and the estimated period of time that the CEMS will be down. The Permittee shall notify the Department by telephone when an out-of-service CEM is back in operation and producing valid data.

[Reference: COMAR 26.11.01.11E(1)]

(6) The Permittee shall submit to the Department quarterly, a CEMS summary report not later than 30 days following each calendar quarter to demonstrate compliance with the NO_x emissions limits. The report shall include the following information:

- (a) The cause, time periods, and magnitude of all emissions which exceed the applicable emission standards;

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 2

- (b) The source downtime including the time and date of the beginning and end of each downtime period and whether the source downtime was planned or unplanned;
- (c) The time periods and cause of all CEM downtime including records of any repairs, adjustments, or maintenance that may affect the ability of the CEM to meet performance specifications of emission data;
- (d) Quarterly totals of excess emissions, installation downtime, and CEM downtime during the calendar quarter;
- (e) Quarterly quality assurance activities;
- (f) Daily calibration activities that include reference values, actual values, absolute or percent of span differences, and drift status; and
- (g) Other information required by the Department that is determined to be necessary to evaluate the data, to ensure that compliance is achieved, or to determine the applicability of this regulation.

[Reference: COMAR 26.11.01.11E(2)(c) & COMAR 26.11.40.04B]

(7) The Permittee shall submit within 30 days following each January 1st and July 1st, a semi-annual report to the U.S. EPA for the immediately preceding half-calendar year period. This report shall:

- (a) Identify any and all dates on which the Permittee has installed, or describe the progress of installation of the low NO_x burner required for NO_x control, emission limits, CEMs, and monitoring requirements and describe any problems encountered or anticipated during such installation, together with implemented or proposed solutions;
- (b) Provide all CEMS data collected for Boiler 6 including an explanation of any periods of CEMS downtime together with any missing data for which the Permittee applied and missing data substitution procedures under Section VI.B of the District Court Consent Decree;
- (c) Demonstrate compliance with all applicable 30-day rolling average emission limits in Section V of the District Court Consent Decree; and
- (d) Describe the status of any operation and maintenance work relating to activities under the District Court Consent Decree.

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section IX(38) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014) & COMAR 26.11.40.04A(2)]

C. Operational Limitations

See Record Keeping Requirements and Reporting Requirements of Control of Nitrogen Oxides.

"A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above."

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 3	
3.0	<p><u>Emissions Unit Number(s): R29-1</u></p> <p>R29-1 – Raw Sugar Unloading and Conveying (MDE Reg. No. 6-2019).</p>
3.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - Visible Emission Standards. C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.” A(2) General Exceptions. “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03C(1) - Particulate Matter from Unconfined Sources. “A person may not cause or permit emissions from an unconfined source without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, when appropriate as determined by the Department, the installation and use of hoods, fans, and dust collectors to enclose, capture, and vent emissions. In making this determination, the Department shall consider technological feasibility, practicality, economic impact, and the environmental consequences of the decision.”</p>
3.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
3.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u></p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 3

	<p>The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.</p> <p>If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:</p> <ol style="list-style-type: none"> (1) Inspect all process and/or control equipment that may affect visible emissions; (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated; (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. <p>[Reference: COMAR 26.11.03.06]</p> <p>B. <u>Control of Particulate Matter</u></p> <p>The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan.</p> <p>[Reference: COMAR 26.11.03.06]</p>
<p>3.4</p>	<p><u>Record Keeping Requirements:</u></p> <p>Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u></p> <p>The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request.</p> <p>[Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u></p> <p>The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:</p> <ol style="list-style-type: none"> (1) a copy of the preventative maintenance plan for equipment installed to minimize dusting; and

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 3	
	(2) a log with records of the dates and description of maintenance activity performed. [Reference: COMAR 26.11.03.06C]
3.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> COMAR 26.11.01.07C – Report of Excess Emissions “(1) In the case of any occurrence of excess emissions, expected to last or actually lasting for 1 hour or more, from any installation required by COMAR 26.11.02.13 to obtain a State permit to operate, the owner or operator shall report the onset and shall report the termination of the occurrence to the Department by telephone. (2) Telephone reports of excess emissions shall include the following information: (a) The identity of the installation and the person reporting; (b) The nature or characteristics of the emissions (for example, hydrocarbons, fluorides); (c) The time of occurrence of the onset of the excess emissions and the actual or expected duration of the occurrence; and (d) The actual or probable cause of the excess emissions.”</p> <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 4	
4.0	<p><u>Emissions Unit Number(s): R29-3, 4; S7B-2; S7-12; S7-13, & S7-14</u></p> <p>R29-3: Melter Feed R29-4: Diatomite Fugitives S7B-2: Bin Tower Rejects Box (MDE Reg. No. 8-0212) S7-12: Maltodex Supersack Unloading System (MDE Reg. No. 8-0266) S7-13: Remelt Shredder Fugitives S7-14: Magnets Tailings Fugitives (MDE Reg. No. 8-0223)</p>
4.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u></p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 4	
	<p>COMAR 26.11.06.02 - <u>Visible Emission Standards.</u> C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.” A(2) <u>General Exceptions.</u> “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03B(2) - <u>Particulate Matter from Confined Sources.</u> “(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).”</p>
4.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
4.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation. If visible emissions in the exhaust gases are visible, the Permittee shall perform the following: (1) Inspect all process and/or control equipment that may affect visible emissions;</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 4	
	<p>(2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;</p> <p>(3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and</p> <p>(4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. [Reference: COMAR 26.11.03.06]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. [Reference: COMAR 26.11.03.06]</p>
4.4	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. [Reference: COMAR 26.11.03.06]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for equipment installed to minimize dusting; and (2) a log with records of the dates and description of maintenance activity performed. [Reference: COMAR 26.11.03.06C]</p>
4.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> See Record Keeping Requirements.</p> <p>B. <u>Control of Particulate Matter</u></p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 4	
	See Record Keeping Requirements.

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 5	
5.0	<p><u>Emissions Unit Number(s): D28-1; D10-1; D10-2; D10-3</u></p> <p><u>Carbonation System:</u> D28-1: Lime silo equipped with a baghouse (RP-C-1). (MDE Reg. No. 8-0301) D10-1: Saturator 1 equipped with a demister and a scrubber (RP-C-2). (MDE Reg. No. 8-0301) D10-2: Saturator 2 equipped with a demister and a scrubber (RP-C-3). (MDE Reg. No. 8-0301) D10-3: Saturator 3 equipped with a demister and a scrubber (RP-C-4). (MDE Reg. No. 8-0301)</p>
5.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - Visible Emission Standards. C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.” A(2) General Exceptions. “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03B(2) - Particulate Matter from Confined Sources. (2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).”</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 5	
5.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
5.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation. If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:</p> <ol style="list-style-type: none"> (1) Inspect all process and/or control equipment that may affect visible emissions; (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated; (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. <p>[Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. [Reference: COMAR 26.11.03.06C]</p>
5.4	<p><u>Record Keeping Requirements:</u></p> <p>Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 5	
	<p>A. <u>Control of Visible Emissions</u> The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for each dust collector; (2) records of the dust collector malfunction, and the corrective action taken to bring it back into proper operation; and (3) a log with records of the dates and description of maintenance activity performed. [Reference: COMAR 26.11.03.06C]</p>
5.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> See Record Keeping Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 6	
6.0	<p><u>Emissions Unit Number(s): D2-1 & U5-1</u></p> <p>D2-1: Mud Loading (MDE Reg. No.8-0301).</p> <p>U5-1: Cooling Tower (MDE Reg. No. 8-0383).</p>
6.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - <u>Visible Emission Standards.</u> C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.”</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 6	
	<p>A(2) <u>General Exceptions.</u> “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:</p> <p>(a) The visible emissions are not greater than 40 percent opacity; and</p> <p>(b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03C(1) - <u>Particulate Matter from Unconfined Sources.</u> “A person may not cause or permit emissions from an unconfined source without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, when appropriate as determined by the Department, the installation and use of hoods, fans, and dust collectors to enclose, capture, and vent emissions. In making this determination, the Department shall consider technological feasibility, practicality, economic impact, and the environmental consequences of the decision.”</p>
6.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
6.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation. If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:</p> <p>(1) Inspect all process and/or control equipment that may affect visible emissions;</p> <p>(2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 6	
	<p>(3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and</p> <p>(4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. [Reference: COMAR 26.11.03.06C]</p>
6.4	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for equipment installed to minimize dusting; and (2) a log with records of the dates and description of maintenance activity performed. [Reference: COMAR 26.11.03.06C]</p>
6.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> See Record Keeping Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 7	
7.0	<p><u>Emissions Unit Number(s): S5-1 thru S5-6; S5-8A thru S5-8G; S7A-1; S7-5 thru S7-7; S7-8A thru S7-8D; S7-10A & S7-10B; S7B-1, S7-11A thru S7-11C.</u></p> <p>S5-1: Scrap Melter 1 equipped with a rotoclone scrubber(RP-C-10). (MDE Reg. No. 8-0226)</p> <p>S5-2: Scrap Melter 2 (MDE Reg. No. 8-0382)</p> <p>S5-3: Remelt Screw Conveyors (MDE Reg. No. 8-0382)</p> <p>S5-4: Invert system controlled by a rotoclone scrubber (RP-C-10). This system consists of the following equipment: [S5-4A – Invert Cloudy Tank (5-3-16) S5-4B – Invert Precoat Tank (5-3-17) S5-4C – Sucrose Cloudy Tank (5-3-13) S5-4D – Sucrose Precoat Tank (5-3-14) S5-4E – Clear Sucrose Tank (5-3-12) S5-4F – Clear Invert Tank (5-3-15)]. (MDE Reg. No. 6-2022)</p> <p>S5-5: Caustic Fugitives associated with the invert system. (MDE Reg. No. 6-2022)</p> <p>S5-6: Soft Sugar Shredder. (MDE Reg. No. 6-2020)</p> <p>S5-8A-B: Two (2) Dryers (Powdered Specialty Sugars) each equipped with a venturi scrubber (DW-1) (RP-C-33), (DW-2) (RP-C-34).</p> <p>S5-8D: Liquid Sugar Cooler (Powdered Specialty Sugars) equipped with a Sly venturi scrubber (WS-1) (RP-C-35).</p> <p>S5-8E: Three (3) Centrifugal Separators (Powdered Specialty Sugars) equipped with a Sly venturi scrubber (WS-1) (RP-C-36).</p> <p>S5-8F: Washout Tanks and Beater controlled by a Rotoclone.</p> <p>S5-8G: Packaging and Conveying Equipment controlled by a Sly venturi scrubber (WS-1) (RP-C-36). (MDE Reg. No. 8-0332)</p> <p>S1-1: FEECO Rotary sugar dryer equipped with an Entoleter vortex scrubber (RP-C-15) (MDE Reg. No. 0320)</p> <p>S7A-1: Bulk Sugar Conveying System equipped with a scrubber (RP-C-25). This system consists of the following equipment: [S7A-RE1 – Bucket Elevator RE-1,</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 7

S7A-XE1 – Bucket Elevator XE-1,
 S7A-XRS1 – Bucket Elevator XRS-1,
 S7A-UE1 – Bucket Elevator UE-1,
 S7A-UE2A – Bucket Elevator UE-2A,
 S7A-UE2B – Bucket Elevator UE-2B,
 S7A-RE2 – Bucket Elevator RE-2,
 S7A-U1 – Storage Bin U1,
 S7A-U2 – Storage Bin U2,
 S7A-U3 – Storage Bin U3,
 S7A-U4 – Storage Bin U4,
 S7A-U5 – Storage Bin U5,
 S7A-U6 – Storage Bin U6,
 S7A-XF1 – Storage Bin XF1,
 S7A-XF2 – Storage Bin XF2,
 S7A-V1 – Storage Bin V1,
 S7A-V2 – Storage Bin V2,
 S7A-V3 – Storage Bin V3,
 S7A-V4 – Storage Bin V4,
 S7A-V5 – Storage Bin V5,
 S7A-V6 – Storage Bin V6,
 S7A-C1 – Storage Bin C1,
 S7A-F1 – Storage Bin F1,
 S7A-AR1 – Storage Bin AR1,
 S7A-AR2 – Storage Bin AR2,
 S7A-AR3 – Storage Bin AR3,
 S7A-AR4 – Storage Bin AR4,
 S7A-AR5 – Storage Bin AR5,
 S7A-AR6 – Storage Bin AR6,
 S7A-AR7 – Storage Bin AR7,
 S7A-AR8 – Storage Bin AR8, and
 S7A-RJX – Screw Conveyor Rejects Transfer].
 (MDE Reg. No. 8-0212)

S7-5, S7-6, S7-7: Packaging Feed Tanks each equipped with a filter
 (RP-C-26, -27 & -28, respectively). (MDE Reg. No. 8-0265)
S7-8: Packaging Operations controlled by a rotoclone scrubber (7-6-1)
 (RP-C-29). This system consists of the following equipment:
 [S7-8A: Fawema Packaging System,
 S7-8B: Paxall Packaging System,
 S7-8C: Clouds Packaging System, and
 S7-8D: Handi Pak System]. (MDE Reg. No. 8-0265)

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 7	
	<p>S7-10: Packaging System controlled by a Wheelabrator dust collector (7-5-1) (RP-C-30). [S7-10A: Hesser Bagging System. S7-10B: Supersack Unloading System]. (MDE Reg. No. 8-0265)</p> <p>S7B-1: Bulk Loading System with an Entoleter scrubber (RP-C-31) and DCL UN800 Dust Collectors. (MDE Reg. No. 8-0223)</p> <p>S7-11: Super-Sack Sugar Packaging Line controlled by Wheelabrator dust collectors. [S7-11A: Thiele Supersack System, S7-11B: Tub Packaging Line controlled by Wheelabrator 7-5-2 (RP-C-30), and S7-11C: Simplex Packaging Line controlled by a Wheelabrator dust collector 6-5-1 (RP-C-12)]. (MDE Reg. No. 8-0287)</p>
7.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - Visible Emission Standards. C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.” A(2) General Exceptions. “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03B - Particulate Matter from Confined Sources. (2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).” COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction. “A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 7	
	<p>airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:</p> <p>(1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.</p> <p>(2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.</p> <p>(3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.</p> <p>(4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.</p> <p>(5) The paving of roadways and their maintenance in clean condition.</p> <p>(6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water.”</p>
7.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
7.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation. If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:</p> <p>(1) Inspect all process and/or control equipment that may affect visible emissions;</p> <p>(2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 7

	<p>(3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and</p> <p>(4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u></p> <p>(1) The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. [Reference: COMAR 26.11.03.06C]</p> <p>(2) The exhaust gases from two liquid sugar dryers (VD1 and VD-2), the liquid sugar coolers (VC-1) and three centrifugal separators (SK-1, SK-2, and SK-3) shall be vented through the cyclonic separator and the venturi scrubber, when the specialty sugar refining process is operating.</p> <p>(3) The exhaust gases from the washout tanks/beater shall be vented through the rotoclone scrubber when the specialty sugar refining process is operating.</p> <p>(4) The exhaust gases from the packing and conveying equipment shall be vented through the rotoclone and the venturi scrubber when the specialty sugar refining process is operating. [Reference: MDE Permit to Construct #510-8-0332 (July 10, 2003)].</p>
7.4	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u></p> <p>(1) The Permittee shall maintain records of the amount and type of specialty sugar produced each month for the specialty sugar refining process equipped with four venturi scrubbers shall be kept at the site for at least five (5) years and shall be made available to the Department upon</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 7	
	<p>request. [Reference: MDE Permit to Construct #510-8-0332 (July 10, 2003)].</p> <p>(2) The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:</p> <p>(a) a copy of the preventative maintenance plan for each dust collector;</p> <p>(b) records of the dust collector malfunction, and the corrective action taken to bring it back into proper operation; and</p> <p>(c) a log with records of the dates and description of maintenance activity performed.</p> <p>[Reference: COMAR 26.11.03.06C]</p>
7.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> See Record Keeping Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 8	
8.0	<p><u>Emissions Unit Number(s): S6-4 thru S6-7.</u></p> <p>S6-4: BMA Granulator equipped with an Entoleter Scrubber (RP-C-11). (MDE Reg. No. 8-0115)</p> <p>S6-5: Sugar Packaging Line and Conveying Systems controlled by a shared Wheelabrator dry filter (RP-C-12, RP-C-13, and RP-C-14). This line consists of the following equipment:</p> <p>[S6-5A: Remelt Shredder, S6-5B: Maltrin Tank, S6-5C: Sugar Tank, S6-5D: MFB Feeder, S6-5E : Sugar Feed to Mill 1, S6-5F: Sugar Feed to Mill 2, S6-5G: Sugar Feed to Mill 3,</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 8

	<p>S6-5H: 6-5-1200 Receiver, S6-5I: UB-1 South Hood, and S6-5J: UB-1 Tail End]. (MDE Reg. No. 8-0222)</p> <p>S6-6: Sugar Packaging Line and Conveying Systems controlled by a shared Wheelabrator dry filter (RP-C-12, RP-C-13, and RP-C-14). This line consists of the following equipment: [S6-6A: Oscillator, S6-6B: DSE-1 (9-25-10), S6-6C: US-2 Scroll, and S6-6D: UB-1 North]. (MDE Reg. No. 8-0296)</p> <p>S6-7: Sugar Packaging Line and Conveying Systems controlled by a shared Wheelabrator dry filter (RP-C-12, RP-C-13, and RP-C-14). [S6-7A: Receiver 1300 2#, S6-7B: Old V. Bag Packaging System, S6-7C: Receiver 1250, S6-7D: Receiver 6-4-1300, S6-7E: 2# Poly Filler System, S6-7F: New V.B. Filler System, S6-7G: Old V.B. Filler System, S6-7H: Packet Grinder, and S6-7I: 1-4 10X Filler System]. (MDE Reg. No. 8-0225) [S6-7J: Bulkline (Super sack: 1-ton bag) Packaging Line]. (MDE Reg. No. 8-0409}</p>
8.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - Visible Emission Standards. C(2)"In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers." A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03B - Particulate Matter from Confined Sources.</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 8

	<p>“(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).”</p> <p>COMAR 26.11.06.03D - <u>Particulate Matter from Materials Handling and Construction.</u></p> <p>“A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:</p> <p>(1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.</p> <p>(2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.</p> <p>(3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.</p> <p>(4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.</p> <p>(5) The paving of roadways and their maintenance in clean condition.</p> <p>(6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water.”</p>
<p>8.2</p>	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
<p>8.3</p>	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 8

	<p>emissions can escape to the outside. The Permittee shall record the results of each observation. If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:</p> <ol style="list-style-type: none"> (1) Inspect all process and/or control equipment that may affect visible emissions; (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated; (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. <p>[Reference: COMAR 26.11.03.06C]</p> <p>B. Control of Particulate Matter</p> <ol style="list-style-type: none"> (1) The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. [Reference: COMAR 26.11.03.06C] (2) The exhaust gases from the packing and conveying equipment shall be vented through the rotoclone and the venturi scrubber when the specialty sugar refining process is operating. [Reference: MDE Permit to Construct #510-0314-8-0409 (June 19, 2020)].
<p>8.4</p>	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. Control of Visible Emissions The Permittee shall maintain for at least five (5) years and make available to the Department upon request: a record of the results of the monthly inspections and the log of inspection and maintenance; and a log with records of the dates and description of maintenance activities performed. [Reference: COMAR 26.11.03.06C & MDE Permit to Construct #510-0314-8-0409 (June 19, 2020)]</p> <p>B. Control of Particulate Matter</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 8	
	<p>(1) The Permittee shall maintain records of the amount and type of specialty sugar produced each month for the specialty sugar refining process equipped with four venturi scrubbers shall be kept at the site for at least five (5) years and shall be made available to the Department upon request. [Reference: MDE Permit to Construct #510-0314-8-0409 (June 19, 2020)].</p> <p>(2) The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:</p> <ul style="list-style-type: none"> (a) a copy of the preventative maintenance plan for each dust collector; (b) records of the dust collector malfunction, and the corrective action taken to bring it back into proper operation; and (c) a log with records of the dates and description of maintenance activity performed. <p>[Reference: COMAR 26.11.03.06C]</p>
8.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> COMAR 26.11.01.07C – Report of Excess Emissions “(1) In the case of any occurrence of excess emissions, expected to last or actually lasting for 1 hour or more, from any installation required by COMAR 26.11.02.13 to obtain a State permit to operate, the owner or operator shall report the onset and shall report the termination of the occurrence to the Department by telephone. (2) Telephone reports of excess emissions shall include the following information:</p> <ul style="list-style-type: none"> (a) The identity of the installation and the person reporting; (b) The nature or characteristics of the emissions (for example, hydrocarbons, fluorides); (c) The time of occurrence of the onset of the excess emissions and the actual or expected duration of the occurrence; and (d) The actual or probable cause of the excess emissions.” <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 9	
9.0	<p><u>Emissions Unit Number(s): S6-1, S6-1A, S6-2, S6-2A, S6-3, S6-3A, S6-8, & S6-9.</u></p> <p>S6-1: Sugar Mill 1 equipped with MAC dry filter (RP-C-16) (MDE Reg. No. 8-0209).</p> <p>S6-1A: Starch Receiver 1 equipped with a dry filter (RP-C-17). (MDE Reg. No. 8-0209)</p> <p>S6-2: Sugar Mill 2 equipped with MAC dry filter (RP-C-18) (MDE Reg. No. 8-0209).</p> <p>S6-2A: Starch Receiver 2 equipped with a dry filter (RP-C-19). (MDE Reg. No. -8-0209)</p> <p>S6-3: Sugar Mill 3 equipped with MAC dry filter (RP-C-20) (MDE Reg. No. 8-0125).</p> <p>S6-3A: Starch Receiver 3 equipped with a dry filter (RP-C-21). (MDE Reg. No. 8-0125)</p> <p>S6-8: Sugar Pulverizer (Mill 7) equipped with a Mikropul baghouse (RP-C-24). (MDE Reg. No. 8-0266)</p> <p>S6-9: Starch Bin equipped with a vent filter (RP-C-22). (MDE Reg. No. 8-0125)</p>
9.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - Visible Emission Standards. C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.” A(2) General Exceptions. “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03B - Particulate Matter from Confined Sources. “(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).” COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction.</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 9	
	<p>“A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:</p> <p>(1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.</p> <p>(2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.</p> <p>(3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.</p> <p>(4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.</p> <p>(5) The paving of roadways and their maintenance in clean condition.</p> <p>(6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water.”</p>
9.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
9.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation. If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:</p> <p>(1) Inspect all process and/or control equipment that may affect visible emissions;</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 9	
	<p>(2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;</p> <p>(3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and</p> <p>(4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. [Reference: COMAR 26.11.03.06C]</p>
9.4	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (a) a copy of the preventative maintenance plan for each dust collector; (b) records of the dust collector malfunction, and the corrective action taken to bring it back into proper operation; and (c) a log with records of the dates and description of maintenance activity performed. [Reference: COMAR 26.11.03.06C]</p>
9.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> See Record Keeping Requirements.</p> <p>B. <u>Control of Particulate Matter</u></p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 9	
	See Record Keeping Requirements.

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 10	
10.0	<p><u>Emissions Unit Number(s): S5-7, S7-15, & S7-16.</u></p> <p>S5-7: Ten (10) Evaporation Pans (Pan 1 thru 9 and 11) (MDE Reg. No. 6-2021) S7-15: Packaging Video Inkjet Printers (MDE Reg. No. 6-0218) S7-16: Packaging Adhesive Fugitives (MDE Reg. No. 9-1298).</p>
10.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - <u>Visible Emission Standards.</u> C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.” A(2) <u>General Exceptions.</u> “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of VOC Emissions</u> Video Inkjet Packaging Lines- S7-15 (MDE Reg. No. 6-2018) COMAR 26.11.09.02I. - <u>Good Operating Practices, Equipment Cleanup, and VOC Storage.</u> “(1) <u>Applicability.</u> The requirements in this section apply to a person who owns or operates an installation that is subject to any requirement in this chapter. (2) <u>Good Operating Practices.</u> (a) A person who is subject to this section shall implement good operating practices to minimize VOC emissions into the atmosphere. (b) Good operating practices shall, at a minimum, include the following: (i) Provisions for training of operators on practices, procedures, and maintenance requirements that are consistent with the equipment</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 10

manufacturers' recommendations and the source's experience in operating the equipment, with the training to include proper procedures for maintenance of air pollution control equipment;

- (ii) Maintenance of covers on containers and other vessels that contain VOC and VOC-containing materials when not in use;
- (iii) Minimize spills of VOC-containing cleaning materials;
- (iv) Convey VOC-containing cleaning materials from one location to another in closed containers or pipelines;
- (v) Minimize VOC emissions from cleaning of storage, mixing, and conveying equipment;
- (vi) As practical, scheduling of operations to minimize color or material changes when applying VOC coatings or other materials by spray gun;
- (vii) For spray gun applications of coatings, use of high-volume low pressure (HVLP) or other high efficiency application methods where practical; and
- (viii) As practical, mixing or blending materials containing VOC in closed containers and taking preventive measures to minimize emissions for products that contain VOC.

(c) A person subject to this regulation shall:

- (i) Establish good operating practices in writing;
- (ii) Make the written operating practices available to the Department upon request; and
- (iii) Display the good operating practices so that they are clearly visible to the operator or include them in operator training.

(3) Equipment Cleanup.

(a) A person subject to this section shall take all reasonable precautions to prevent or minimize the discharge of VOC into the atmosphere when cleaning process and coating application equipment, including containers, vessels, tanks, lines, and pumps.

(b) Reasonable precautions for equipment cleanup shall, at a minimum, include the following:

- (i) Storing all wastes and waste materials, including cloth and paper that are contaminated with VOC, in closed containers;
- (ii) Preparing written standard operating procedures for frequently cleaned equipment, including when practical, provisions for the use of low-VOC or non-VOC materials and procedures to minimize the quantity of VOC materials used;
- (iii) Using enclosed spray gun cleaning, VOC-recycling systems and other spray gun cleaning methods where practical that reduce or eliminate VOC emissions; and
- (iv) Using, when practical, detergents, high-pressure water, or other non-VOC cleaning options to clean coating lines, containers, and process equipment.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 10

(4) VOC Storage and Transfer.

(a) A person subject to this section who stores VOCs shall, at a minimum, install conservation vents or other vapor control measures on storage tanks with a capacity of 2,000 gallons or more to minimize VOC emissions.

(b) A person subject to this section shall, at a minimum, utilize vapor balance, vapor control lines, or other vapor control measures when VOCs are transferred from a tank truck into a stationary storage tank with a capacity greater than 10,000 gallons and less than 40,000 gallons that store VOCs or materials containing VOCs, other than gasoline, that have a vapor pressure greater than 1.5 psia.”

COMAR 26.11.19.16C. - General Requirements.

“A person subject to this regulation shall comply with all of the following requirements:

(1) Visually inspect all components on the premises for leaks at least once each calendar month.

(2) Tag any leak immediately so that the tag is clearly visible. The tag shall be made of a material that will withstand any weather or corrosive conditions to which it may be normally exposed. The tag shall bear an identification number, the date the leak was discovered, and the name of the person who discovered the leak. The tag shall remain in place until the leak has been repaired.

(3) Take immediate action to repair all observed VOC leaks that can be repaired within 48 hours.

(4) Repair all other leaking components not later than 15 days after the leak is discovered. If a replacement part is needed, the part shall be ordered within 3 days after discovery of the leak, and the leak shall be repaired within 48 hours after receiving the part.

(5) Maintain a supply of components or component parts that are recognized by the source to wear or corrode, or that otherwise need to be routinely replaced, such as seals, gaskets, packing, and pipe fittings.

(6) Maintain a log that includes the name of the person conducting the inspection and the date on which leak inspections are made, the findings of the inspection, and a list of leaks by tag identification number. The log shall be made available to the Department upon request. Leak records shall be maintained for a period of not less than 2 years from the date of their occurrence.”

COMAR 26.11.19.06D. Exceptions. “Components that cannot be repaired as required in this regulation because they are inaccessible, or that cannot be repaired during operation of the source, shall be identified in the log and included within the source’s maintenance schedule for repair during the next source shutdown.”

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 10

COMAR 26.11.19.18B. Applicability.

“(1) This regulation applies to a person, owner, or operator who:
 (d) Performs screen printing on untreated sign paper at a premises that causes VOC emissions of 20 pounds or more per day from all printing on untreated sign paper at the premises.”

F. General Requirements for Digital Imaging.

“A person who owns or operates digital imaging that is subject to this regulation may not cause the discharge of VOC emissions into the atmosphere in excess of 100 pounds on any day from all digital printing at the premises.”

COMAR 26.11.35 – VOC from Adhesives and Sealants

Packaging Adhesive Fugitive Lines S7-16 (MDE Reg. No. 9-1298)

COMAR 26.11.35.01 – Applicability and Exemptions

E. “The provisions of Regulation .04A and D of this chapter do not apply to the use of adhesives, sealants, adhesive primers, sealant primers, cleanup solvents, and surface preparation solvents if:

- (1) The total volume of noncomplying adhesives, sealants, primers, cleanup solvents, and surface preparation solvents applied facility-wide does not exceed 55 gallons per calendar year; and
- (2) The person claiming the usage exemption under §E(1) of this regulation maintains monthly operational records sufficient to demonstrate compliance as required by Regulation .05A of this chapter.

Note: In any calendar year in which ASR uses more than 55 gallons of packaging adhesives, ASR must meet the requirements of COMAR 26.11.35.04A and C.

COMAR 26.11.35.04 - Standards.

A. “Except as provided in §E of this regulation and Regulation .01 of this chapter, on and after January 1, 2009, a person may not:

- (3) Use or apply an adhesive, sealant, adhesive primer, or sealant primer within the State that exceeds the applicable VOC content limits specified in Table 1.”

COMAR 26.11.35.04G - Table 1.

VOC Content Limits for Adhesives, Sealants, Adhesive Primers, Sealant Primers, and Adhesives Applied to Particular Substrates		
Adhesive, sealant, adhesive primer, or sealant primer	VOC content limit	
Category	VOC (grams per liter*)	VOC (pounds per gallon*)

**AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 10

Adhesives Applied to the Listed Substrate		
Porous material	120	1.00

* The VOC content is determined as the weight of volatile compounds, less water and exempt compounds, as specified in Regulation .06 of this chapter.

COMAR 26.11.35.04C. - Surface Preparation or Cleanup Solvent.

- “(1) This section applies to a person subject to this chapter using a surface preparation or cleanup solvent.
 (2) Except as provided in §C(3) of this regulation for single-ply roofing, a person may not use materials for surface preparation containing VOCs unless the VOC content of the surface preparation solvent is less than 70 grams per liter.
 (3) If a surface preparation solvent is used in applying single-ply roofing, a person may not use materials for surface preparation containing VOCs unless the composite vapor pressure, excluding water and exempt compounds, of the surface preparation solvent does not exceed 45 millimeters of mercury at 20°C.
 (4) Except as provided in §C(5) of this regulation, a person may not use materials containing VOCs for the removal of adhesives, sealants, or adhesive or sealant primers from surfaces, other than spray application equipment, unless the composite vapor pressure of the solvent used is less than 45 millimeters of mercury at 20°C.
 (5) Removal of an adhesive, sealant, adhesive primer, or sealant primer from the parts of spray application equipment shall be performed as follows:
 (a) In an enclosed cleaning system or equivalent cleaning system as determined by the test method identified in Regulation .06H of this chapter;
 (b) Using a solvent with a VOC content less than or equal to 70 grams of VOC per liter of material; or
 (c) Parts containing dried adhesive may be soaked in a solvent if the composite vapor pressure of the solvent, excluding water and exempt compounds, is less than or equal to 9.5 millimeters of mercury at 20°C and the parts and solvent are in a closed container that remains closed except when adding parts to or removing parts from the container.”
- COMAR 26.11.35.04E.** “A person using adhesives, sealants, adhesive primers, sealant primers, surface preparation solvents, or cleanup solvents subject to this chapter shall store or dispose of all absorbent materials, such as cloth or paper, that are moistened with adhesives, sealants, primers, or solvents subject to this chapter in nonabsorbent

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 10	
	<p>containers that are closed except when placing materials in or removing materials from the container.”</p> <p>COMAR 26.11.35.04F. “A person may not solicit, require the use, or specify the application of an adhesive, sealant, adhesive primer, sealant primer, surface preparation solvent, or cleanup solvent if the use or application results in a violation of this chapter. This requirement applies to all written or oral contracts under which an adhesive, sealant, adhesive primer, sealant primer, surface preparation solvent, or cleanup solvent subject to this chapter is to be used at a location in the State.”</p>
10.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Reporting Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
10.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Reporting Requirements.</p> <p>B. <u>Control VOC Emissions</u> <i>Video Inkjet Packaging Lines: S7-15 (MDE Reg. No. 6-2018)</i> The Permittee shall conduct facility-wide inspections at least once per calendar month to determine the compliance status of facility operations with regard to implementation of “good operating practices” designed to minimize emissions of VOC. [Reference: COMAR 26.11.03.06C]</p> <p>The Permittee shall:</p> <ol style="list-style-type: none"> (1) Visually inspect all components (process equipment, storage tanks, pumps, compressors, valves, flanges, pipeline fittings, pressure relief valves) at the facility for VOC leaks at least once each calendar month; (2) Tag any VOC leak immediately with I.D. Number, the date VOC leak was discovered, and the name of the person who discovered the VOC leak. The tag is to remain in place until the VOC leak is repaired; (3) Take immediate action to repair/control all observed VOC leaks that can be repaired within 48 hours; (4) Repair all other VOC leaking components not later than 15 days after the VOC leak is discovered in accordance with COMAR 26.11.19.16C(4);

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 10

(5) If a replacement part is needed, it shall be ordered within 3 days after discovery of the VOC leak and the leak shall be repaired within 48 hours after receiving the part;

(6) Maintain a supply of components or component parts that are recognized by the source to wear or corrode, or that otherwise need to be routinely replaced; and

(7) Identify in a log, components that cannot be repaired as required by this regulation because they are inaccessible, or that cannot be repaired during operation of the source and include them within the source's maintenance schedule for repair during the next source shutdown.

[Reference: COMAR 26.11.19.16C and D]

Packaging Adhesive Fugitive lines only (MDE Reg. No. 510-0314-9-1298)

(1) The Permittee shall not use any adhesive with a VOC content of greater than 1.0 pound per gallon (120 grams per liter). The VOC content is determined as the weight of volatile compounds, less water and exempt compounds as specified in COMAR 26.11.36.06.

[Reference: COMAR 26.11.35.04G, Table 1, footnote]

(2) The Permittee shall not use materials for surface preparation containing VOCs unless the VOC content of the surface preparation solvent is less than 70 grams per liter. **[Reference: COMAR 26.11.36.04C(2)]**

(3) The Permittee shall not use materials containing VOCs for the removal of adhesives, sealants, or adhesive or sealant primers from surfaces other than spray application equipment, unless the composite vapor pressure of the solvent used is less than 45 millimeters of mercury at 20°C. Removal of an adhesive sealant, adhesive primer, or sealant primer from the parts of spray application equipment shall be performed according to COMAR 26.11.36.04C(5). **[Reference: COMAR 26.11.36.04C(4) and (5)]**

(5) The Permittee shall store or dispose of all absorbent materials, such as cloth or paper, that are moistened with adhesives, sealants, primers, or solvents subject to COMAR 26.11.36 in nonabsorbent containers that are closed except when placing materials in or removing materials from the container. **[Reference: COMAR 26.11.36.04E]**

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 10

10.4	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> See Reporting Requirements.</p> <p>B. <u>Control of VOC Emissions</u> <i>Video Inkjet Packaging Lines S7-15 (MDE Reg. No. 6-2018)</i> The Permittee shall maintain: (a) Written descriptions of all “good operating practices” designed to minimize emissions of VOC from facility-wide operations. [Reference: COMAR 26.11.19.02I] (b) Records of all inspections conducted to determine the facility’s compliance status with regard to implementation of “good operating practices” designed to minimize emissions of VOC from facility-wide operations. The records shall include for each inspection the name of the inspector, the date and time of the inspection, and an account of the findings. [Reference: COMAR 26.11.03.06C]</p> <p>The Permittee shall: (a) Maintain a log that includes the name of the person conducting the inspection, the date on which VOC leak inspection was made, the findings of the inspection, a list of VOC leaks by tag identification number, the date the part was ordered, and the date the VOC leak was repaired; and (b) Make the log available to the Department upon request and shall be maintained for a period of not <u>less</u> than two years from the date of the VOC leaks’ occurrence. [Reference: COMAR 26.11.19.16C(6)]</p> <p>COMAR 26.11.19.18G - <u>Record Keeping.</u> “A person subject to this regulation shall maintain the following records for not less than 3 years and make the records available to the Department upon request: (3) The VOC content of each ink, coating, cleanup material, or any other material containing VOC that is used at the premises.</p>
10.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> The Permittee shall report all occurrences of excess emissions to the Department. [Reference: COMAR 26.11.01.07].</p> <p>B. <u>Control of VOC Emissions</u></p>

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 10	
	<p><i>Video Inkjet Packaging Lines S7-15 (MDE Reg. No. 6-2018)</i> Good operating practices information as required by COMAR 26.11.19.02I shall be made available to the Department upon request.</p> <p>VOC Leak inspection logs as required by COMAR 26.11.19.16 shall be made available to the Department upon request.</p> <p><i>Packaging Adhesive Fugitive lines only S7-16 (MDE Reg. No. 510-0314-9-1298)</i> The Permittee shall report all occurrences of excess emissions to the Department. [Reference: COMAR 26.11.01.07]</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

Table IV – 11	
11.0	<p><u>Emissions Unit Number(s): D3-6 thru D3-11</u></p> <p><i>Ion Exchange System</i></p> <p>D3-6: Scrubber (25-gpm once through). D3-6A: HCl Tank (8450-gallons equipped with scrubber D3-6). D3-7: Resin Acid Wash Tank (12,924 gallons). D3-8: Clean in Place (CIP) Tank (734 gallons). D3-9A, B, C, D: Four (4) Deashing Resin Beds (10, 574 gallons each). D3-10A, B, C, D: Four (4) Decolorized Resin Beds (23,603 gallons each). D3-11A, B: Two (2) salt saturators controlled by water spray chamber (D3-11). D3-12: HCl equipment leak components (valves/pumps/ connectors). (MDE Reg. No. 510-0314-8-0386).</p>
11.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - Visible Emission Standards. C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.”</p>

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

Table IV – 11

A(2) General Exceptions. “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”

B. Control of Particulate Matter

COMAR 26.11.06.03B - Particulate Matter from Confined Sources.

“(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).”

COMAR 26.11.06.03C - Particulate Matter from Unconfined Sources.

“(1) A person may not cause or permit emissions from an unconfined source without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, when appropriate as determined by the Department, the installation and use of hoods, fans, and dust collectors to enclose, capture, and vent emissions. In making this determination, the Department shall consider technological feasibility, practicality, economic impact, and the environmental consequences of the decision.”

COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction.

“A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:

- (1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.
- (2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.
- (3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 11	
	<p>(4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.</p> <p>(5) The paving of roadways and their maintenance in clean condition.</p> <p>(6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water.”</p>
11.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Record Keeping Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>
11.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Record Keeping Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>
11.4	<p><u>Record Keeping Requirements:</u></p> <p>Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall maintain at the facility for at least five (5) years and make them available to the Department upon request records necessary to support annual certifications of emissions. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:</p> <p>(a) Annual HCl throughput for each tank and resin bed.</p> <p>(b) Annual salt throughput for each salt saturator.</p> <p>(c) All written descriptions of “good operating practices” designed to minimize emissions of HAP.</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 11	
	<p>(d) HAP leak detection and repair logs that include identification of the persons who conducted the leak detection inspections, the dates on which the inspections were conducted, the findings during the inspections, a listing by tag identification number and a description of all leaks discovered, and the date and nature of all leak repairs effected.</p> <p>[Reference: MDE Permit to Construct No. 510-0314-8-0386 (November 18, 2013)]</p>
11.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> The Permittee shall submit to the Department by April 1 of each year a certification of emissions for the previous calendar year.</p> <p>The Permittee shall report all occurrences of excess emissions to the Department. [Reference: COMAR 26.11.01.07]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall submit to the Department by April 1 of each year a certification of emissions for the previous calendar year.</p> <p>The Permittee shall report all occurrences of excess emissions to the Department. [Reference: COMAR 26.11.01.07]</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 12	
12.0	<p><u>Emissions Unit Number(s): S1, S2, S3 & S4</u></p> <p>S1, S2, S3, S4: Four (4) 3.75-million-pound sugar storage silos equipped with bin vents (BV-1, BV-2, BV-3, BV-4) [MDE Reg. No. 510-0314-8-0411]</p>
12.1	<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.06.02 - <u>Visible Emission Standards.</u> C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.” A(2) <u>General Exceptions.</u> “The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if: (a) The visible emissions are not greater than 40 percent opacity; and (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”</p> <p>B. <u>Control of Particulate Matter</u> COMAR 26.11.06.03B - <u>Particulate Matter from Confined Sources.</u> “(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).”</p> <p>COMAR 26.11.06.03D - <u>Particulate Matter from Materials Handling and Construction.</u> “A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer: (1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land. (2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dust. (3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment</p>

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 12	
	<p>methods shall be employed during sandblasting of buildings or other similar operations.</p> <p>(4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.</p> <p>(5) The paving of roadways and their maintenance in clean condition.</p> <p>(6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water.”</p>
12.2	<p><u>Testing Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> See Monitoring Requirements.</p> <p>B. <u>Control of Particulate Matter</u> See Monitoring Requirements.</p>
12.3	<p><u>Monitoring Requirements:</u></p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation. If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:</p> <ol style="list-style-type: none"> (1) Inspect all process and/or control equipment that may affect visible emissions; (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated; (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions. <p>[Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u></p>

AMERICAN SUGAR REFINING, INC. (AI#60)
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PART 70 OPERATING PERMIT NO. 24-510-0314

Table IV – 12	
	<p>The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. [Reference: COMAR 26.11.03.06C]</p>
12.4	<p><u>Record Keeping Requirements:</u> Note: All records must be maintained for a period of 5 years. [Reference: COMAR 26.11.03.06C(5)(g)]</p> <p>A. <u>Control of Visible Emissions</u> The Permittee shall maintain at the facility for at least five (5) years and make them available to the Department upon request, records of the following: (1) A record of the results of the monthly inspections and the log of inspection and maintenance. (2) A log with records of the dates and description of maintenance activities performed. [Reference: COMAR 26.11.03.06C]</p> <p>B. <u>Control of Particulate Matter</u> The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for each of the bin vents; (2) records of the bin vent malfunction, and corrective actions taken to bring it back into proper operation; and (3) a log with records of the dates and description of maintenance activities performed. [Reference: COMAR 26.11.03.06C]</p>
12.5	<p><u>Reporting Requirements:</u></p> <p>A. <u>Visible Emissions Limitations</u> The Permittee shall report, in accordance with the requirements under COMAR 26.11.01.07, occurrences of excess emissions to the Compliance Program of the Air and Radiation Administration. [Reference: COMAR 26.11.01.07]</p> <p>B. <u>Control of Particulate Matter</u> See Record Keeping Requirements.</p>

“A permit shield shall cover the applicable requirements identified for the emissions unit(s) listed in the table above.”

SECTION V INSIGNIFICANT ACTIVITIES

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

This section provides a list of insignificant emissions units that were reported in the Title V permit application. The applicable Clean Air Act requirements, if any, are listed below the insignificant activity.

- (1) No. 1 Stationary internal combustion engines with an output less than 500 brake horsepower (373 kilowatts) and which are not used to generate electricity for sale or for peak or load shaving;

The 250-kW emergency generator is subject to the following requirements:

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

Applicable Standards/Limits:

A. Control of Visible Emissions

COMAR 26.11.09.05E – Stationary Internal Combustion Engine Powered Equipment.

(2) Emissions During Idle Mode. A person may not cause or permit the discharge of emissions from any engine, operating at idle, greater than 10 percent opacity.

(3) Emissions During Operating Mode. A person may not cause or permit the discharge of emissions from any engine, operating at other than idle conditions, greater than 40 percent opacity.

(4) Exceptions.

(a) Section E(2) of this regulation does not apply for a period of 2 consecutive minutes after a period of idling of 15 consecutive minutes for the purpose of clearing the exhaust system.

(b) Section E(2) of this regulation does not apply to emissions resulting directly from cold engine start-up and warm-up for the following maximum periods:

(i) Engines that are idled continuously when not in service: 30 minutes;

(ii) All other engines: 15 minutes.

(c) Section E(2) and (3) of this regulation do not apply while maintenance, repair, or testing is being performed by qualified mechanics.”

B. Control of Sulfur Oxides Emission

COMAR 26.11.09.07A(2) – Control of Sulfur Oxides from fuel burning equipment. “A person may not burn, sell, or make available for sale any fuel with a sulfur content by weight in excess of or which otherwise exceeds the following limitations: In Areas III and IV: **(b) Distillate fuel oil, 0.3 percent.**”

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

C. Control of Nitrogen Oxides Emission

COMAR 26.11.09.08G. - Requirements for Fuel-Burning Equipment with a Capacity Factor of 15 Percent or Less, and Combustion Turbines with a Capacity Factor Greater than 15 Percent.

"(1) A person who owns or operates fuel-burning equipment with a capacity factor (as defined in 40 CFR Part 72.2) of 15 percent or less shall:

- (a) Provide certification of the capacity factor of the equipment to the Department in writing;
- (b) For fuel-burning equipment that operates more than 500 hours during a calendar year, perform a combustion analysis and optimize combustion at least once annually;
- (c) Maintain the results of the combustion analysis at the site for at least 2 years and make these results available to the Department and the EPA upon request;
- (d) Require each operator of an installation, except combustion turbines, to attend operator training programs at least once every 3 years, on combustion optimization that are sponsored by the Department, the EPA, or equipment vendors; and
- (e) Maintain a record of training program attendance for each operator at the site and make these records available to the Department upon request."

D. Control of HAPs

Subpart III—Standards of Performance for Stationary Compression Ignition Internal Combustion Engines

§60.4200 - Am I subject to this subpart?

(a) The provisions of this subpart are applicable to manufacturers, owners, and operators of stationary compression ignition (CI) internal combustion engines (ICE) and other persons as specified in paragraphs (a)(1) through (4) of this section. For the purposes of this subpart, the date that construction commences is the date the engine is ordered by the owner or operator.

(1) Manufacturers of stationary CI ICE with a displacement of less than 30 liters per cylinder where the model year is: 2007 or later, for engines that are not fire pump engines.

§60.4205 - What emission standards must I meet for emergency engines if I am an owner or operator of a stationary CI internal combustion engine?

(b) Owners and operators of 2007 model year and later emergency stationary CI ICE with a displacement of less than 30 liters per cylinder that are not fire pump engines must comply with the emission standards for new nonroad CI

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

engines in § 60.4202, for all pollutants, for the same model year and maximum engine power for their 2007 model year and later emergency stationary CI ICE.

Note: The Permittee shall satisfy the requirements above and §60.4202 by purchasing and installing engines certified at EPA Tier 2 or better.

§60.4207 - What fuel requirements must I meet if I am an owner or operator of a stationary CI internal combustion engine subject to this subpart?

(b) Beginning October 1, 2010, owners and operators of stationary CI ICE subject to this subpart with a displacement of less than 30 liters per cylinder that use diesel fuel must use diesel fuel that meets the requirements of 40 CFR 80.510(b) for nonroad diesel fuel, except that any existing diesel fuel purchased (or otherwise obtained) prior to October 1, 2010, may be used until depleted.

§60.4209 - What are the monitoring requirements if I am an owner or operator of a stationary CI internal combustion engine?

If you are an owner or operator, you must meet the monitoring requirements of this section. In addition, you must also meet the monitoring requirements specified in § 60.4211.

(a) If you are an owner or operator of an emergency stationary CI internal combustion engine that does not meet the standards applicable to non-emergency engines, you must install a non-resettable hour meter prior to startup of the engine.

(b) If you are an owner or operator of a stationary CI internal combustion engine equipped with a diesel particulate filter to comply with the emission standards in § 60.4204, the diesel particulate filter must be installed with a backpressure monitor that notifies the owner or operator when the high backpressure limit of the engine is approached.

§60.4211 - What are my compliance requirements if I am an owner or operator of a stationary CI internal combustion engine?

(a) If you are an owner or operator and must comply with the emission standards specified in this subpart, you must do all of the following, except as permitted under paragraph (g) of this section:

(1) Operate and maintain the stationary CI internal combustion engine and control device according to the manufacturer's emission-related written instructions;

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

(2) Change only those emission-related settings that are permitted by the manufacturer; and

(3) Meet the requirements of 40 CFR part 1068, as they apply to you.

(c) If you are an owner or operator of a 2007 model year and later stationary CI internal combustion engine and must comply with the emission standards specified in §60.4204(b) or §60.4205(b), or if you are an owner or operator of a CI fire pump engine that is manufactured during or after the model year that applies to your fire pump engine power rating in table 3 to this subpart and must comply with the emission standards specified in §60.4205(c), you must comply by purchasing an engine certified to the emission standards in §60.4204(b), or §60.4205(b) or (c), as applicable, for the same model year and maximum (or in the case of fire pumps, NFPA nameplate) engine power. The engine must be installed and configured according to the manufacturer's emission-related specifications, except as permitted in paragraph (g) of this section.

(f) If you own or operate an emergency stationary ICE, you must operate the emergency stationary ICE according to the requirements in paragraphs (f)(1) through (3) of this section. In order for the engine to be considered an emergency stationary ICE under this subpart, any operation other than emergency operation, maintenance and testing, and operation in nonemergency situations for 50 hours per year, as described in paragraphs (f)(1) through (3), is prohibited. If you do not operate the engine according to the requirements in paragraphs (f)(1) through (3), the engine will not be considered an emergency engine under this subpart and must meet all requirements for non-emergency engines.

(1) There is no time limit on the use of emergency stationary ICE in emergency situations.

(2) You may operate your emergency stationary ICE for any combination of the purposes specified in paragraphs (f)(2)(i) of this section for a maximum of 100 hours per calendar year. Any operation for non-emergency situations as allowed by paragraph (f)(3) of this section counts as part of the 100 hours per calendar year allowed by this paragraph (f)(2).

(i) Emergency stationary ICE may be operated for maintenance checks and readiness testing, provided that the tests are recommended by

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

federal, state or local government, the manufacturer, the vendor, the regional transmission organization or equivalent balancing authority and transmission operator, or the insurance company associated with the engine. The owner or operator may petition the Administrator for approval of additional hours to be used for maintenance checks and readiness testing, but a petition is not required if the owner or operator maintains records indicating that federal, state, or local standards require maintenance and testing of emergency ICE beyond 100 hours per calendar year.

(ii) –(iii) [Reserved]

(3) Emergency stationary ICE may be operated for up to 50 hours per calendar year in non-emergency situations. The 50 hours of operation in non-emergency situations are counted as part of the 100 hours per calendar year for maintenance and testing and emergency demand response provided in paragraph (f)(2) of this section. Except as provided in paragraph (f)(3)(i) of this section, the 50 hours per calendar year for non-emergency situations cannot be used for peak shaving or non-emergency demand response, or to generate income for a facility to an electric grid or otherwise supply power as part of a financial arrangement with another entity.

(i) The 50 hours per year for non-emergency situations can be used to supply power as part of a financial arrangement with another entity if all of the following conditions are met:

- (A) The engine is dispatched by the local balancing authority or local transmission and distribution system operator;
- (B) The dispatch is intended to mitigate local transmission and/or distribution limitations so as to avert potential voltage collapse or line overloads that could lead to the interruption of power supply in a local area or region.
- (C) The dispatch follows reliability, emergency operation or similar protocols that follow specific NERC, regional, state, public utility commission or local standards or guidelines.
- (D) The power is provided only to the facility itself or to support the local transmission and distribution system.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

(E) The owner or operator identifies and records the entity that dispatches the engine and the specific NERC, regional, state, public utility commission or local standards or guidelines that are being followed for dispatching the engine. The local balancing authority or local transmission and distribution system operator may keep these records on behalf of the engine owner or operator.

(ii) [Reserved]

§60.4214 - What are my notification, reporting, and recordkeeping requirements if I am an owner or operator of a stationary CI internal combustion engine?

(d) If you own or operate an emergency stationary CI ICE with a maximum engine power more than 100 HP that operates for the purpose specified in § 60.4211(f)(3)(i), you must submit an annual report according to the requirements in paragraphs (d)(1) through (3) of this section.

(1) The report must contain the following information:

(i) Company name and address where the engine is located.

(ii) Date of the report and beginning and ending dates of the reporting period.

(iii) Engine site rating and model year.

(iv) Latitude and longitude of the engine in decimal degrees reported to the fifth decimal place.

(v)-(vi) [Reserved]

(vii) Hours spent for operation for the purposes specified in § 60.4211(f)(3)(i), including the date, start time, and end time for engine operation for the purposes specified in § 60.4211(f)(3)(i). The report must also identify the entity that dispatched the engine and the situation that necessitated the dispatch of the engine.

40 CFR 63 Subpart ZZZZ—National Emissions Standards for Hazardous Air Pollutants for Stationary Reciprocating Internal Combustion Engines.

§63.6590 - What parts of my plant does this subpart cover?

"(c) *Stationary RICE subject to Regulations under 40 CFR Part 60.* An affected source that meets any of the criteria in paragraphs (c)(1) through (7) of this section must meet the requirements of this part by meeting the requirements of 40 CFR part 60 subpart IIII, for compression ignition engines or 40 CFR part 60 subpart JJJJ, for spark ignition engines. No further requirements apply for such engines under this part.

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

(1) A new or reconstructed stationary RICE located at an area source;"

- (2) Space heaters utilizing direct heat transfer and used solely for comfort heat;
- (3) No. 5 Unheated VOC dispensing containers or unheated VOC rinsing containers of 60 gallons (227 liters) capacity or less;

The affected units are subject to COMAR 26.11.19.09D, which requires that the Permittee control emissions of volatile organic compounds (VOC) from cold degreasing operations by meeting the following requirements:

- (a) COMAR 26.11.19.09D(2)(b), which establishes that the Permittee shall not use any VOC degreasing material that exceeds a vapor pressure of 1 mm Hg at 20 ° C;
- (b) COMAR 26.11.19.09D(3)(a—d), which requires that the Permittee implement good operating practices designed to minimize spills and evaporation of VOC degreasing material. These practices, which shall be established in writing and displayed such that they are clearly visible to operators, shall include covers (including water covers), lids, or other methods of minimizing evaporative losses, and reducing the time and frequency during which parts are cleaned;
- (c) COMAR 26.11.19.09D(4), which prohibits the use of any halogenated VOC for cold degreasing.

The Permittee shall maintain on site for at least five (5) years, and shall make available to the Department upon request, the following records of operating data:

- (a) Monthly records of the total VOC degreasing materials used; and

AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314

- (b) Written descriptions of good operating practices designed to minimize spills and evaporation of VOC degreasing materials.
- (4) Containers, reservoirs, or tanks used exclusively for:
- (a) Storage of butane, propane, or liquefied petroleum, or natural gas;
 - (b) No. 4 Storage of lubricating oils;
 - (c) No. 2 Storage of Numbers 1, 2, 4, 5, and 6 fuel oil and aviation jet engine fuel;
 - (d) No. 1 The storage of VOC normally used as solvents, diluents, thinners, inks, colorants, paints, lacquers, enamels, varnishes, liquid resins, or other surface coatings and having individual capacities of 2,000 gallons (7.6 cubic meters) or less;
- (5) Charbroilers and pit barbecues as defined in COMAR 26.11.18.01 with a total cooking area of 5 square feet (0.46 square meter) or less;
- (6) First aid and emergency medical care provided at the facility, including related activities such as sterilization and medicine preparation used in support of a manufacturing or production process;
- (7) Comfort air conditioning subject to requirements of Title VI of the Clean Air Act;
- (8) Laboratory fume hoods and vents;

For the following, attach additional pages as necessary:

- (9) any other emissions unit, not listed in this section, with a potential to emit less than the "de minimus" levels listed in COMAR 26.11.02.10X (list and describe units):

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

No. 2 Aerosol can puncture equipment. _____

No. 1 Maintenance welding (U11-3) _____

No. 1 Maintenance steel cutting (U11-4) _____

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

SECTION VI STATE-ONLY ENFORCEABLE CONDITIONS

The Permittee is subject to the following State-only enforceable requirements:

1. Applicable Regulations:

(A) **COMAR 26.11.06.08 - Nuisance.**

"An installation or premises may not be operated or maintained in such a manner that a nuisance or air pollution is created. Nothing in this regulation relating to the control of emissions may in any manner be construed as authorizing or permitting the creation of, or maintenance of, nuisance or air pollution."

(B) **COMAR 26.11.06.09 - Odors.**

"A person may not cause or permit the discharge into the atmosphere of gases, vapors, or odors beyond the property line in such a manner that a nuisance or air pollution is created."

(C) **COMAR 26.11.15.05, Control Technology Requirements.**

"A person who complies with the ambient impact requirement in Regulation .06 of this chapter may not be affected by the amount of the installation's stack height that exceeds good engineering practice (GEP), or by any other dispersion technique.

Unless an existing installation is controlled using T-BACT, the degree of emission limitation required in order to demonstrate compliance with Regulation .06 of this chapter may not be affected by the amount of the installation's stack height that exceeds good engineering practice (GEP), or by any other dispersion technique."

(D) **COMAR 26.11.15.06, Ambient Impact Requirement – Requirements for Existing Installations, Sources, or Premises.**

- 1) "Except as provided in §B(3) of this regulation, a person may not cause or permit the discharge of a toxic air pollutant listed in COMAR 26.11.16.07 from an existing installation or source if total allowable emissions of that TAP from the premises will unreasonably endanger human health.
- 2) A person shall demonstrate compliance with §B(1) of this regulation using the procedures established in Regulation .07 of this chapter and COMAR 26.11.16.
- 3) A person who owns or operates an existing premises shall meet the requirements of §B(1) and (2) of this regulation for each TAP listed in COMAR 26.11.16.07 by the applicable compliance dates listed in COMAR 26.11.16.07, or not later than 2 years after becoming subject to this chapter, whichever is later."

**AMERICAN SUGAR REFINING, INC. (AI#60)
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PART 70 OPERATING PERMIT NO. 24-510-0314**

2. Record Keeping and Reporting:

The Permittee shall submit to the Department, by April 1 of each year during the term of this permit, a written certification of the results of an analysis of emissions of toxic air pollutants from the Permittee's facility during the previous calendar year. The analysis shall include either:

- (a) a statement that previously submitted compliance demonstrations for emissions of toxic air pollutants remain valid; or
- (b) a revised compliance demonstration, developed in accordance with requirements included under COMAR 26.11.15 & 16, that accounts for changes in operations, analytical methods, emissions determinations, or other factors that have invalidated previous demonstrations.

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

BACKGROUND

American Sugar Refining, Inc. (ASR) operates a sugar manufacturing plant which produces granulated and confectioner's sugars from raw cane sugar in bulk quantities and in various package sizes. The facility also manufactures bulk quantities of liquid cane sugars and syrups for industrial consumption. The sugar manufacturing process consists of two principal processes: decolorization and sugar production. The facility also operates a centralized steam and electrical cogeneration energy production facility (powerhouse). There are four (4) boilers (130 million Btu/hr. each) which fire natural gas and that fire fuel oil (No. 2 or No. 6) in curtailment and testing situations. There is also one (1) boiler which will be rated at 300 million Btu/hr that burns natural gas only.

The sugar manufacturing plant is located at 1100 Key Highway East in Baltimore, Maryland. The primary SIC code for this facility is 2062, sugar cane refining.

The following table summarizes the actual emissions from American Sugar Refining, Inc. based on its Annual Emission Certification Reports:

Table 1: Actual Emissions

Year	NO _x (TPY)	SO _x (TPY)	PM ₁₀ /PM _{2.5} (TPY)	CO (TPY)	VOC (TPY)	Total HAP (TPY)
2022	65.3	0.63	25.2/	85.9	8.6	0.059
2021	46.25	0.89	25.15/4.99	76.18	9.65	0.047
2020	135.13	0.85	31.77/8.31	104.17	12.64	0.13
2019	68.83	0.75	28.87/6.35	84.12	10.60	0.00539
2018	49.81	0.78	28.20/5.79	78.70	9.26	0.00523

The major source threshold for triggering Title V permitting requirements in Baltimore City is 25-tons per year for VOC, 25-tons for NO_x, and 100 tons per year for any other criteria pollutants and 10-tons for a single HAP or 25-tons per year for total HAPs. Since the actual NO_x and PM₁₀ emission from the facility are greater than the major source threshold, American Sugar Refining Inc. is required to obtain a Title V – Part 70 Operating Permit under COMAR 26.11.03.01.

The Department received the American Sugar Refining, Inc's Part 70-permit renewal application on November 1, 2022. An administrative completeness review was conducted, and the application was deemed complete. A completeness determination letter was sent to American Sugar Refining, Inc on November 17, 2022, granting American Sugar Refining, Inc. an application shield.

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

CHANGES AND MODIFICATIONS TO THE PART 70 OPERATING PERMIT

The following changes and/or modifications that have occurred since the previous permit was issued have been incorporated into the renewal Title V – Part 70 Operating Permit for American Sugar Refining, Inc.

Additions:

June 19, 2020: Permit to Construct (510-0314-8-0409) issued for Bulk Powdered Sugar Tote Packaging Line (S6-7J).

February 25, 2021: Permit to Construct (510-0314-8-0410 & 8-0411) issued for Four (4) new sugar storage silos (S1-S4) and associated equipment (BV-1 through BV-4, BE-1, AC-2A, AC-2B, AC-9) controlled by a Schenck dust collector (DV-1). This project is fully operational as of September 1, 2023.

April 9, 2021: Permit to Construct (510-0314-8-0225 and 8-0296) issued for Modification to the existing 10X Filler System (S6-7I).

August 5, 2021: Permit to Construct (510-0314-6-3091) issued for Old Sugar Shed Conveyance System to/from Storage Barge.

A few control device references were incorrectly identified in the 2018 permit renewal. The following changes reflect the proper equipment:

- Scrap Melter 1 (S5-1) is controlled by a Rotoclone (RP-C-1) not RP-C10.
- Packaging system (S7-10) is controlled by a Wheelabrator dust collector (7-5-1)(RP-C-32) not RP-C-30.
- The “Super-Sack” Packaging Line (S7-11) is controlled by a Wheelabrator dust collector (7-5-2)(RP-C-30) not 7-5-1.

Removal

Replacement of 100-kW emergency generator with a 250-kW emergency generator (U11-2). No permit to construct required because it is less than 500-bhp (373-kW). Listed in insignificant activity list. An Administrative Amendment was submitted, and Administrative Completeness was issued April 23, 2020.

Removal of sources due to the fire in 2021 at the Raw Sugar Shed. The following equipment was destroyed and is no longer in operation: Raw Sugar Shed (R29-2), Conveyors R2B-6 and RSB-9, and Shuttle RSS-3. An Administrative Amendment was submitted, and Administrative Completeness was issued April 30, 2021.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

NSPS and MACT

American Sugar Refining, Inc is subject to the NSPS (40 CFR Part 60)

- Subpart Db- Standards of Performance for Industrial-Commercial-Institutional Steam Generating Units: (C6): Boiler 6 – 300-MMBtu/hr. natural gas fired boiler. (MDE Reg. 5-1476)
- Subpart IIII—Standards of Performance for Stationary Compression Ignition Internal Combustion Engines. (U11-2): 250-kW emergency generator.

American Sugar Refining, Inc is not a major HAP Emissions Source. Instead, it is an area HAP emission source and is subject to the following MACT (40 CFR Part 63):

- Subpart ZZZZ—Requirements for Existing Stationary RICE Located at Area Sources of HAP Emissions. (U11-2): 250-kW emergency generator. Compliance with NSPS requirements meets the NESHAP requirements.

COMPLIANCE ASSURANCE MONITORING

American Sugar Refining, Inc. conducted a Compliance Assurance Monitoring (CAM) analysis for the facility and determined that the facility is not subject to the (CAM) Rule 40 CFR Subpart 64. CAM is intended to provide a reasonable assurance of compliance with applicable requirements under the Clean Air Act for large emission units that rely on air pollution control (APC) equipment to achieve compliance. The CAM approach establishes monitoring for the purpose of: (1) documenting continued operation of the control measures within ranges of specified indicators of performance (such as emissions, control device parameters, and process parameters) that are designed to provide a reasonable assurance of compliance with applicable requirements; (2) indicating any excursions from these ranges; and (3) responding to the data so that the cause or causes of the excursions are corrected. In order for a unit to be subject to CAM, the unit must be located at a major source, be subject to an emission limitation or standard; use a control device to achieve compliance; have post-control emissions of at least 100% of the major source amount (for initial CAM submittals); and must not otherwise be exempt from CAM. Applicability determinations are made on a pollutant-by-pollutant basis for each emission unit.

Emissions units at the refinery do not use “control devices” (as defined in 40 CFR Part 64) to meet emission limits or standards. The refinery baghouses, cyclones, dust collectors, and venture scrubbers/rotoclones are “inherent process equipment” as defined. Thus, the refinery does not have pre-control device emissions and is not subject to the applicability criteria of 40 CFR Part 64.2(a)(3) and 64.5(A).

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

GREENHOUSE GAS (GHG) EMISSIONS

American Sugar Refining, Inc. emits the following greenhouse gases (GHGs) related to Clean Air Act requirements: carbon dioxide, methane, and nitrous oxide. These GHGs originate from various processes (i.e., internal combustion engines, and boilers) contained within the facility premises applicable to ASR Inc. The facility has not triggered Prevention of Significant Deterioration (PSD) requirements for GHG emissions; therefore, there are no applicable GHG Clean Air Act requirements. While there may be no applicable requirements as a result of PSD, emission certifications reports showed that ASR, Inc exceeded the major source (threshold: 100,000tpy CO_{2e}) for GHG's (see Table 3 shown below). The Permittee shall quantify facility wide GHGs emissions and report them in accordance with Section 3 of the Part 70 permit.

The following table summarizes the actual emissions from American Sugar Refining, Inc. based on its Annual Emission Certification Reports:

Table 2: Greenhouse Gases Emissions Summary

GHG	Conversion factor	2020 tpy CO_{2e}	2021 tpy CO_{2e}	2022 tpy CO_{2e}
Carbon dioxide CO ₂	1	119,734.98	108,001	122,262.40
Methane CH ₄	25	2.394	2.038	2.30
Nitrous Oxide N ₂ O	298	0.219	0.204	0.230
Total GHG CO_{2eq}		119,737.59	108,003.80	122,264.93

EMISSION UNIT IDENTIFICATION

American Sugar Refining, Inc. has identified the following emission units as being subject to Title V permitting requirements and having applicable requirements.

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Table 3: Emission Unit Identification

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
C1 thru C4	5-1444 thru 5-1447	Four (4) Combustion Engineering Boilers, each rated at 130 million Btu/hr. firing natural gas and No. 2 fuel oil. Boilers 1 thru 4.	1966; Modified 6/12/2012
C6	5-1476	One (1) Babcock & Wilcox boiler rated at 300 million Btu/hr. firing natural gas and equipped with a low-NO _x burner and flue gas recirculation.	July 2000; Modified 1/18/2013 and 2018
R29-1	6-3091	Raw Sugar Unloading and Conveying. Modified 2021: additional equipment for transfer of raw sugar – Old Sugar Shed Conveyance system to/from Storage Barge. [PTC issued Aug 5, 2021]	Aug 2021
R29-3	N/A	Melter Feed	1971
R29-4	N/A	Diatomite Fugitives	1971
S7B-2	8-0212	Bin Tower Rejects Box	1966
S7-12	8-0266	Maltodex Supersak Unloading System	1982
S7-13	N/A	Remelt Shredder Fugitives	1989
S7-14	8-0223	Magnets Tailing Fugitives	1966
D28-1	8-0301	Carbonatation Process – Lime silo equipped with a baghouse	1995
D10-1, 2, 3		Carbonatation Process – Saturators demisters (RP-C-1, -2, -3, respectively) and controlled by a Ducon Flue Gas Scrubber.	1995
D2-1	8-0301	Mud Loading	1964
D3-5	N/A	Char Filtration Process – Celite Fugitives	
U5-1	8-0383	Cooling Tower CT-3	Unknown
S5-1	8-0226	Scrap melter equipped with a Rotoclone scrubber (RP-C-1)	1922
S5-2	8-0382	Scrap melter	1991
S5-3		Remelt Screw Conveyors	1991
S5-4	6-2022	Invert System with a Rotoclone [S5-4A: Invert Cloudy Tank; S5-4B: Invert Precoat Tank; S5-4C: Surcose Cloudy Tank; S5-4D: Surcose Precoat Tank; S5-4E: Clear Surcose Tank; S5-4F: Clear Invert Tank]	1958
S5-5		Caustic fugitives associated with the invert System	1958
S5-6	6-2020	Soft Sugar Shredder	1969

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
S5-8A-B	8-0332	Two (2) Dryers (Powdered Specialty Sugars) each equipped with venturi scrubbers (DW-1) (RP-C-33), DW-2 (RP-C-34), respectively.	Feb 2004
S5-8D		Liquid Sugar Cooler (Powdered Specialty Sugars) controlled by Sly Venturi Scrubber (WS-1) (RP-C-35).	Feb 2004
S5-8E		Three (3) Centrifugal Separators controlled by Sly Venturi Scrubber (WS-1) (RP-C-36)	Feb 2004
S5-8F		Washout Tanks and Beater controlled by a Rotoclone.	Feb 2004
S5-8G		Packaging and Conveying Equipment controlled by Sly Venturi Scrubber (WS-1) (RP-C-36)	Feb 2004
S1-1	8-0320	FEECO Rotary sugar dryer equipped with Entoleter vortex scrubber (RP-C-15)	1999
S7A-1	8-0212	Bulk Sugar Conveying System controlled by a scrubber (RP-C-25) [S7A-RE1: Bucket Elevator RE-1; S7A-XE1: Bucket Elevator XE-1; S7A-XRS1: Bucket Elevator XRS-1; S7A-UE1: Bucket Elevator UE-1; S7A-UE2A: Bucket Elevator UE-2A; S7A-UE2B: Bucket Elevator UE-2B; S7A-RE2: Bucket Elevator RE-2; S7A-U1: Storage Bin U1; S7A-U2: Storage Bin U2; S7A-U3: Storage Bin U3; S7A-U4: Storage Bin U4; S7A-U5: Storage Bin U5; S7A-U6: Storage Bin U6; S7A-XF1: Storage Bin XF-1; S7A-XF2: Storage Bin XF-2; S7A-V1: Storage Bin V1; S7A-V2: Storage Bin V2; S7A-V3: Storage Bin V3; S7A-V4: Storage Bin V4; S7A-V5: Storage Bin V5; S7A-V6: Storage Bin V6; S7A-C1: Storage Bin C1; S7A-F1: Storage Bin F1; S7A-AR1: Storage Bin AR1; S7A-AR2: Storage Bin AR2; S7A-AR3: Storage Bin AR3; S7A-AR4: Storage Bin AR4;	1966

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
		S7A-AR5: Storage Bin AR5; S7A-AR6: Storage Bin AR6; S7A-AR7: Storage Bin AR7; S7A-AR8: Storage Bin AR8; S7A-RJX: Screw Conveyor Rejects.	
S7-5, S7-6, S7-7	8-0265	Packaging Feed Tanks each equipped with a filter (RP-C-26, -27, & -28, respectively)	Jan 2001
S7-8		Packaging Operations controlled by Rotoclone 7-6-1 (RP-C-29) [S7-8A: Fawema Packaging System; S7-8B: Paxall Packaging System; S7-8C: Clouds Packaging System; S7-8D: Handi Pak System]	Jan 2001
S7-10		Packaging System controlled by a Wheelabrator dust collector (7-5-1) (RP-C-32) [S7-10A: Hesser Bagging System; S7-10B: Supersack Unloading System]	Jan 2001
S7B-1	8-0223	Bulk Loading System with an Entoleter scrubber (RP-C-31) and DCL UN800 Dust Collectors	1966; Modified Feb 2016
S7-11	8-0287	Supersack Sugar Packing Line controlled by Wheelabrator dust collectors. [S7-11A: Thiele Supersack system; S7-11B: Tub Packaging Line controlled by Wheelabrator 7-5-2 (RP-C-30); S7-11C: Simplex Packaging Line controlled by a Wheelabrator dust collector 6-5-1 (RP-C-12)]	1990
S6-4	8-0115	BMA Granulator equipped with Rotoclone (RP-C-11)	1969
S6-5	8-0225	Sugar Packaging Line and Conveying System controlled by a Wheelabrator dry filter (6-5-1) (RP-C-12) [S6-5A: Remelt Shredder; S6-5B: Maltrin Tank; S6-5C: Sugar Tank; S6-5D: MFB Feeder; S6-5E-G: 3 Sugar Feed to Mills 1, 2, & 3; S6-5H: 6-5-1200 Receiver; S6-5I: UB-1 South Hood; S6-5J: UB-1 Tail End]	Nov 2008; Modified Apr 2021
S6-6	8-0115	Sugar Packaging Line and Conveying System controlled by a Wheelabrator dry filter (6-5-2) (RP-C-13)	Nov 2008

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
		[S6-6A: Oscillator; S6-6B: DSE-1; S6-6C: US-2 Scroll; S6-6D: UB-1 North]	
S6-7	8-0296 / 8-0409	Sugar Packaging Line and Conveying System controlled by a Wheelabrator dry filter (6-5-3) (RP-C-14) [S6-7A: Receiver 1300 2#; S6-7B: Old V-Bag Packaging System; S6-7C: Receiver 1250; S6-7D: Receiver 6-4-1300; S6-7E: 2# Poly Filler System; S6-7F: New V.B. Filler System; S6-7G: Old V.B Filler System; S6-7H: Packet Grinder; S6-7I: 1-4 10X Filler System; S6-7J: Bulkline (Supersack) Packaging Line – June 2020 – MDE Reg. 510-0314-8-0409]	Nov 2008 / Jun 2020; Modified Apr. 2021
S6-1	8-0209	Sugar Mill 1 equipped with MAC dry filer (RP-C-16)	Nov 2008
S6-1A		Starch Receiver 1 equipped with dry filer (RP-C-17)	Nov 2008
S6-2		Sugar Mill 2 equipped with MAC dry filer (RP-C-18)	Nov 2008
S6-2A		Starch Receiver 2 equipped with dry filer (RP-C-19)	Nov 2008
S6-3	8-0125	Sugar Mill 3 equipped with MAC dry filer (RP-C-20)	Nov 2008
S6-3A		Starch Receiver 3 equipped with dry filer (RP-C-21)	Nov 2008
S6-8	8-0266	Sugar Pulverizer (Mill 7) equipped with Mikropul baghouse (RP-C-24)	1988
S6-9	8-0209	Starch Bin equipped with vent filter (RP-C-22)	Nov 2008
S5-7	6-2021	Ten (10) Evaporation Pans (#1-9, 11)	1950
S7-15	6-2018	Packaging Video Inkjet Printers	1990
S7-16	9-1298	Packaging Adhesives Fugitives: additional adhesive (H.B. Fuller – Swift@Tak 5948-00) for substitution of original adhesives.	1990; Mod. 2022
D3-6	8-0386	Ion Exchange System: Scrubber (25-gpm once-through)	2013
D3-6A		HCl Tank (8,450-gallons) equipped with scrubber D3-6	
D3-7		Resin Acid Wash Tank (12,924-gallons)	

**AMERICAN SUGAR REFINING, INC.
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PERMIT NO. 24-510-0314
 PART 70 OPERATING PERMIT FACT SHEET**

Emissions Unit Number	MDE - ARA Registration Number	Emissions Unit Name and Description	Date of Installation
D3-8		Clean in Place (CIP) Tank (734-gallons)	
D3-9A, B, C, D		Four (4) Deashing Resin Beds (10,574-gallon, each)	
D3-10A, B, C, D		Four (4) Decolorized Resin Beds (23,603-gallons, each)	
D3-11A, B		Two (2) Salt saturators controlled by water spray chamber (D3-11)	
D3-12		HCl equipment leak components (valves, pumps, connectors)	
U11-2	9-1293	250-kW Emergency Generator	2020
S1, S2, S3 & S4	8-0411	Four (4) 3.75-million-pound sugar storage silos equipped with bin vents (BV-1, BV-2, BV-3, BV-4) [PTC issued Feb 25, 2021]	2021

AN OVERVIEW OF THE PART 70 PERMIT

The Fact Sheet is an informational document. If there are any discrepancies between the Fact Sheet and the Part 70 permit, the Part 70 permit is the enforceable document.

Section I of the Part 70 Permit contains a brief description of the facility and an inventory list of the emissions units for which applicable requirements are identified in Section IV of the permit.

Section II of the Part 70 Permit contains the general requirements that relate to administrative permit actions. This section includes the procedures for renewing, amending, reopening, and transferring permits, the relationship to permits to construct and approvals, and the general duty to provide information and to comply with all applicable requirements.

Section III of the Part 70 Permit contains the general requirements for testing, record keeping and reporting; and requirements that affect the facility as a whole, such as open burning, air pollution episodes, particulate matter from construction and demolition activities, asbestos provisions, ozone depleting substance provisions, general conformity, and acid rain permit. This section includes the requirement to report excess emissions and deviations, to submit an annual emissions certification report and an annual compliance certification report, and results of sampling and testing.

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Section IV of the Part 70 Permit identifies the emissions standards, emissions limitations, operational limitations, and work practices applicable to each emissions unit located at the facility. For each standard, limitation, and work practice, the permit identifies the basis upon which the Permittee will demonstrate compliance. The basis will include testing, monitoring, record keeping, and reporting requirements. The demonstration may include one or more of these methods.

Section V of the Part 70 Permit contains a list of insignificant activities. These activities emit very small quantities of regulated air pollutants and do not require a permit to construct or registration with the Department. For insignificant activities that are subject to a requirement under the Clean Air Act, the requirement is listed under the activity.

Section VI of the Part 70 Permit contains State-only enforceable requirements. Section VI identifies requirements that are not based on the Clean Air Act, but solely on Maryland air pollution regulations. These requirements generally relate to the prevention of nuisances and implementation of Maryland's Air Toxics Program.

**REGULATORY REVIEW/TECHNICAL REVIEW/COMPLIANCE
METHODOLOGY**

Emission Unit: C1 thru C4

Fuel Burning Equipment

C1 thru C4: Four (4) Combustion Engineering Boilers each rated at 130 MMBtu/hr. firing natural gas and fuel oil (No. 2 or No. 6) (only during periods of natural gas curtailment), and each equipped with an ultra-low NO_x burner. [MDE Reg. Nos. 510-0314-5-1444, 5-1445, 5-1446, and 5-1447].

Background

ASR, Inc. negotiated a District Court Consent Decree with EPA Region III involving the operation of ASR's steam boilers. The District Court Consent Decree was signed and entered into the court docket July 2, 2012. The District Court Consent Decree required ASR to do the following:

- Install ultra-low NO_x burners (ULNB) and continuous emissions monitoring systems (CEMS) on Boilers 2 & 4 and commence operation thereof by September 1, 2012.
- Install ULNB and CEMS on Boilers 1 & 3 and commence operation thereof by February 28, 2013.
- Install ULNB and CEMS on Boiler 6 and commence operation thereof by April 1, 2013.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Note: Per the District Court Order Modifying Consent Decree dated August 5, 2013, the letter from ASR to the EPA dated March 14, 2014, and the response from the EPA dated April 2, 2014, the requirement to install a ULNB on Boiler 6 was removed.

- Restrict NO_x emissions from Boilers 1-4 & 6 to 624 lbs./day, on a 30-day rolling average, by the earlier of April 1, 2013, or the date on which ULNB are operational on Boilers 1-4 & 6 the time which all ULNBs are installed whichever comes first.

Note: Per the District Court Order Modifying Consent Decree dated August 5, 2013, this requirement was modified to include operating scenarios in which Boilers 1-4 and 6 must meet a NO_x emissions limit of 500 lbs./day.

- Restrict NO_x emissions from Boilers 1-4 & 6 to 62 tons during any consecutive 12-month period or 6.0 tons in any calendar month, beginning on April 1, 2013, or the time which all ULNBs are installed whichever comes first.

Note: Per the District Court Order Modifying Consent Decree dated August 5, 2013, the letter from ASR to the EPA dated March 14, 2014, and the response from the EPA dated April 2, 2014, this requirement was modified to limit ASR to NO_x emissions of 60 tons during any consecutive 12-month period.

- Restrict the combined hours of operation of Boilers 1-4 during any consecutive 12-month period to 20,220 hours, beginning 90 days following the effective date of the District Court Consent Decree, and
- Submit an application to MDE no later than 120 days after the establishment of emission limits pursuant to the District Court Consent Decree to incorporate the limit into a federally enforceable permit.

A permit to construct was issued June 12, 2012, for the addition of an Ultra-Low NO_x Burner (ULNB) to each of the four (4) boilers. The addition of these burners is mandated by a District Court Consent Decree with the EPA (Civil Action No. JBK-12-1048, dated May 7, 2012).

A Permit to Construct was issued on August 28, 2014, to incorporate the changes from the District Court Order Modifying Consent Decree dated August 5, 2013.

40 CFR 60, Subpart Db - Standards Of Performance For Industrial-Commercial-Institutional Steam Generating Units:

This regulation does not apply because the boilers were constructed prior to 1984 (40 CFR §60.40b(a)) and the change made to the boilers does not meet the definition of a modification found in 40 CFR §60.2. The definition of a modification indicates that the emissions must increase, or something must be emitted after the modification that was not emitted prior to the modification. The ultra-low NO_x burners will decrease NO_x emissions from these units without increasing any other regulated pollutants.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

40 CFR 63, Subpart DDDDD - National Emission Standards For Hazardous Air Pollutants For Industrial, Commercial, And Institutional Boilers And Process Heaters:

This regulation does not apply because the facility is not a major source of Hazardous Air Pollutants (40 CFR §63.7485).

40 CFR 63, Subpart JJJJJ - National Emission Standards For Hazardous Air Pollutants For Industrial, Commercial, And Institutional Boilers Area Sources:

These boilers are exempt from this regulation because they burn natural gas with fuel oil (No. 2 or No. 6) only being burned during times of natural gas curtailment (40 CFR §63.11195(e)). Gas fired boilers are defined in 40 CFR §63.11237.

Compliance Status:

During the 2022 full compliance report, Boiler #3 was operating on natural gas. PM stack test was conducted on Boilers #1 & #3 on December 12, 2021, burning No. 2 fuel oil. Results showed PM emissions of 0.0014 gr/dscf (corrected to 50% excess air) which is in compliance with the emissions limit of 0.020 gr/dscf @50% EA. Method 9 VE conducted during the stack testing showed no visible emissions. PM stack test was conducted on Boilers #2 & #4, on March 31, 2021, burning No. 2 fuel oil. Results showed PM emissions of 0.0007 gr/dscf (corrected to 50% excess air) which is in compliance with the emissions limit of 0.020 gr/dscf @50% EA. Method 9 VE conducted during the stack testing showed no visible emissions.

EPA Consent Order Reporting Period (July 1, 2022 thru Dec 31, 2022) stated the following: **C1:** experienced a total downtime of 27 hours in the reporting period out of a total operating time of 2380 hours; **C2:** experienced a total downtime of 3 hours in the reporting period out of a total operating time of 1759 hours; **C3:** experienced a total downtime of 11 hours in the reporting period out of a total operating time of 2521 hours; **C4:** experienced a total downtime of 15 hours in the reporting period out of a total operating time of 3122 hours.

Applicable Standards/Limits:

A. Control of Visible Emissions

COMAR 26.11.09.05A - Visible Emissions.

(2) "Areas III and IV. In Areas III and IV, a person may not cause or permit the discharge of emissions from any fuel burning equipment, other than water in an uncombined form, which is visible to human observers except that, for the purpose of demonstrating compliance using COM data, emissions that are visible to a human observer are those that are equal to or greater than 10 percent opacity.

(3) Exceptions. Section A(1) and (2) of this regulation do not apply to emissions during load changing, soot blowing, startup, or adjustments or occasional cleaning of control equipment if:

(a) The visible emissions are not greater than 40 percent opacity; and

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(b) The visible emissions do not occur for more than 6 consecutive minutes in any sixty-minute period.”

Compliance Demonstration

The Permittee shall conduct Method 9, 22 or equivalent method approved by the Department opacity observations for at least one hour during stack testing to demonstrate compliance with the no visible emissions requirement of COMAR 26.11.09.05A(2) when burning fuel oil (No. 2 or No. 6). **[Reference: COMAR 26.11.03.06C & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

The Permittee shall:

- (1) properly operate and maintain the boilers in a manner to prevent visible emissions; and
- (2) verify no visible emissions when burning fuel oil (No. 2 or No. 6). The Permittee shall perform a visual observation for a 6-minute once for each 168-hour period when the boiler burns fuel oil. If a boiler does not burn fuel oil for more than 100 hours in a calendar year, the visible emission observation requirement is waived for that boiler.
- (3) The Permittee shall perform the following if visible emissions are observed:
 - (a) inspect combustion system and boiler operation;
 - (b) perform all necessary adjustments and/or repairs to the boiler within 48 hours so that visible emissions are eliminated;
 - (c) document in writing the results of inspections, adjustments, and/or repair to the boiler; and
 - (d) after 48 hours, if required adjustments and/or repair had not eliminated the visible emissions, perform a Method 9 observation for an 18-minute period once per day until corrective actions have eliminated the visible emissions.

The Permittee shall:

- (1) maintain an operational manual and preventive maintenance plan on site;
- (2) maintain the test result of the Method 9 performed;
- (3) maintain records of the results of the monthly inspections;
- (4) maintain a record of the maintenance performed that relates to combustion performance;
- (5) maintain a log of visible emissions observations performed and make it available to the Department upon request;
- (6) maintain a record of the hours that fuel oil (No. 2 or No. 6) is burned.

[Reference: COMAR 26.11.03.06C].

The Permittee shall report, in accordance with requirements under COMAR 26.11.01.07, occurrences of excess emissions to the Compliance Program of the Air and Radiation Administration.

**AMERICAN SUGAR REFINING, INC.
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PERMIT NO. 24-510-0314
 PART 70 OPERATING PERMIT FACT SHEET**

B. Control of Particulate Matter

(1) **COMAR 26.11.09.06B(1)(a) - Control of Particulate Matter - Areas III and IV – Dust Collector Devices Required.** “A person may not cause or permit the combustion of residual fuel oil in fuel burning equipment unless the equipment is fitted with a dust collector which is so designed that it can reasonably be expected to produce sufficient dust particle force, residence time, and particle retention to satisfy the requirements of Table 1. This paragraph does not apply to fuel burning equipment where by-product gases or by-product gases in combination with residual fuel oil are burned and where the effluent gases do not contain particulate matter in excess of the requirements of Table 1, as applicable to residual oil burning.”

(2) **COMAR 26.11.09.06B(2) - Control of Particulate Matter - Areas III and IV - Residual Fuel-Oil-Burning Equipment.** “A person may not cause or permit particulate matter caused by the combustion of residual fuel oil to be discharged into the atmosphere in excess of the amounts shown in Table 1.”

(3) **COMAR 26.11.09.09: Table 1 - Emission Standards and Dust Collector Performance Standards for Fuel-Burning Equipment.**

Table 1 Emission Standards and Dust Collector Performance Standards for Fuel-Burning Equipment		
<i>Equipment Description</i>	<i>Max. Rated Heat Input in million Btu (gigajoules) per hour per furnace</i>	<i>Max. Allowable Emissions of Part. Matter – gr/scfd (mg/dscm)</i>
Existing and new equipment burning residual oil	Less than 13 (13.7) 13 – 50 (13.7 – 52.8) 50 – 250 (52.8 – 265)	No requirement (a) 0.03 (69) 0.020 (46)

(4) No. 6 fuel oil is limited to a maximum of **0.068% ash content.**
[Reference: MDE letter dated November 8, 2005 & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

Compliance Demonstration

Stack emissions tests shall be conducted at least once every two-year period to demonstrate compliance with the 0.020 gr/scfd particulate matter emission limit when the boiler burns fuel oil (No. 2 or No. 6) with a pre-determined ash content weight percent. Stack emissions tests shall be conducted to demonstrate

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

compliance with the 0.020 gr/scfd particulate matter emission limit can be achieved during either of the following operating conditions:

(1) Burning only fuel oil (No. 2 or No. 6) with a pre-determined ash content weight percent in boilers 1 thru 4; and burning the lowest possible ratio of natural gas to fuel oil (No. 2 or No. 6) in boilers #1 thru #4.

(2) Boilers #1 thru #4 shall each be operated at 90% or higher of their rated capacity during all stack emissions tests. **[Reference: COMAR 26.11.03.06C]**

Note: The Permittee is not required to conduct stack testing on Boilers #1 thru #4 when fuel oil (No. 2 or No. 6) has not been utilized at any time during the preceding two (2) years.

The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the fuel oil (No. 2 or No. 6) has an ash content equal to or less than 0.068% by weight. **[Reference: MDE letter dated November 8, 2005 & COMAR 26.11.03.06C]**

The Permittee shall:

(1) maintain records of all stack emissions test documents and (2) maintain the fuel supplier certification for each shipment of fuel oil (No. 2 or No. 6) stating the ash content in weight percent.

At least 30 days prior to the projected date of the stack emission test, the Permittee shall submit a test protocol to the Department for review and approval. Within 45 days after the emission test, the Permittee shall submit to the Department a stack test report that includes the stack emissions test results and opacity observations results. **[Reference: COMAR 26.11.03.06C]**

C. Control of Sulfur Oxides

(1) **COMAR 26.11.09.07A(2) - Sulfur Content Limitations for Fuel.**

"A person may not burn, sell, or make available for sale any fuel with a sulfur content by weight in excess of or which otherwise exceeds the following limitations: (2) In Areas III and IV:

(a) *Not applicable.*

(b) Distillate fuel oils, 0.3 percent.

(c) Residual fuel oils, 1.0 percent."

(2) No. 6 fuel oil is limited to a maximum of 0.5% sulfur content.

[Reference: MDE letter dated November 8, 2005 & MDE Permit to Construct 510-5-1444 through 5-1447 issued on August 28, 2014]

Compliance Demonstration.

(1) The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the No. 6 fuel oil has a sulfur content equal to or less than 0.5% by weight. **[Reference: MDE letter dated November 8, 2005 & COMAR 26.11.03.06C]**

**AMERICAN SUGAR REFINING, INC.
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PERMIT NO. 24-510-0314
 PART 70 OPERATING PERMIT FACT SHEET**

(2) The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the No. 2 fuel oil has a sulfur content equal to or less than 0.3% by weight. **[Reference: COMAR 26.11.03.06C]**

The Permittee shall maintain records of the annual fuel supplier certifications stating that the No. 6 fuel oil used in Boilers #1 thru #4 is in compliance with the 1.0% by weight sulfur limitation required by COMAR 26.11.09.07A(2)(c). **[Note: Per November 8, 2005, letter from MDE, based on stack testing data, sulfur content of fuel oil is not to exceed 0.5%]**

The Permittee shall maintain records of the annual fuel supplier certifications stating that the No. 2 fuel oil used in Boilers 1 thru 4 is in compliance with the 0.3% by weight sulfur limitation required by COMAR 26.11.09.07A(2)(b).

The Permittee shall maintain records of the certification from the supply company of all natural gas curtailment events, including date and duration of the event.

[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

The Permittee shall make records of certification from the supplier available to the Department upon request. **[Reference: COMAR 26.11.03.06C]**

D. Control of Nitrogen Oxides

(1) **COMAR 26.11.09.08B(1)(c) - Control of NO_x for Major Stationary Sources – Emissions Standards and Requirements.** “Emission Standards in Pounds of NO_x per Million Btu of heat input.”

Fuel	Tangential Fired	Wall-Fired
Gas only	0.20	0.20
Gas/Oil	0.25	0.25
Coal (dry bottom)	0.38	0.38
Coal (wet bottom)	1.00	1.00

(2) **COMAR 26.11.09.08B(5) - Control of NO_x for Major Stationary Sources – Operator Training.**

(a) “For purposes of this regulation, the equipment operator to be trained may be the person who maintains the equipment and makes the necessary adjustments for efficient operation.

(b) The operator training course sponsored by the Department shall include an in-house training course that is approved by the Department.”

(3) **COMAR 26.11.09.08D(1)(b) - Requirements for Fuel-Burning Equipment with a Rated Heat Input Capacity of Less than 250 Million Btu Per Hour and Greater than 100 Million Btu Per Hour.**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

“All other fuel burning equipment with a rated heat input capacity of less than 250 Million Btu per hour and greater than 100 Million Btu per hour shall meet the NO_x emission rates set forth in §B(1)(c) of this regulation.”

(4) No. 6 fuel oil is limited to a maximum of 0.5% nitrogen content.
[Reference: MDE letter dated November 8, 2005 & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

Compliance Demonstration

(1) The Permittee shall obtain an analysis from the fuel supplier of each load of oil received indicating that the oil has a nitrogen content equal to or less than 0.5% by weight. **[Reference: MDE letter dated November 8, 2005 & COMAR 26.11.03.06C]**

(2) At a point in each stack prior to a point at which boiler flue gas combines with flue gas from any other boiler, the Permittee shall install and make operational, concurrent with commencement of operations of the ultra-low NO_x burners, an NO_x continuous emissions monitoring system (CEMS) to monitor NO_x emissions in accordance with the requirements of 40 CFR Part 60. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(15) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(3) The required CEMS shall monitor and record the applicable NO_x Emission Rate for each boiler to demonstrate compliance with the established NO_x Emissions Rates and shall be continuously operated, except during CEMS breakdowns, repairs, calibration checks, and zero span adjustments.
[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(16) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

(4) If the Permittee is unable to obtain emissions data from the CEMS because of a malfunction of the CEM for more than 2 hours in duration, the Permittee shall use the alternative measurement method approved by the Department and EPA.
[Reference: COMAR 26.11.01.11B(4) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

(5) A CEMS used to monitor a gas concentration shall record not less than four equally spaced data points per hour and automatically reduce data in terms of averaging times consistent with the applicable emission standard per COMAR 26.11.01.11D. **[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(6) All emissions of NO_x shall be measured by the CEMS. During any periods of time when any CEMS is inoperable or not measuring NO_x emissions from any boiler, the Permittee shall apply the missing data substitution procedures provided in 40 CFR Part 75, Subpart D. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(18) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(7) **COMAR 26.11.01.11C – Quality Assurance for CEMS**. "A CEM used to monitor a gas concentration shall meet the quality assurance criteria of 40 CFR Part 60, Appendix F, as amended, which is incorporated by reference, or, if applicable, the quality assurance criteria of 40 CFR Part 75, Appendix B, as amended."

The Permittee shall maintain records of the following and make available to the Department upon request:

- (1) The fuel supplier certification for each shipment of fuel oil (No. 2 or No. 6) stating the nitrogen content in weight percent.
- (2) All training and combustion analysis records required by COMAR 26.11.09.08B(5).

[Reference: COMAR 26.11.03.06C]

- (1) The Permittee shall submit a record of training program attendance for each operator to the Department upon request.
- (2) The Permittee shall comply with the CEM System Downtime Reporting Requirements of COMAR 26.11.01.11E as follows:
 - (a) All CEM system downtime that lasts or is expected to last more than 24 hours shall be reported to the Department by telephone before 10 a.m. of the first regular business day following the breakdown.
 - (b) The system breakdown report required by §E(1)(a) of this regulation shall include the reason, if known, for the breakdown and the estimated period of time that the CEM will be down. The owner or operator of the CEM shall notify the Department by telephone when an out-of-service CEM is back in operation and producing data that has met performance specifications for accuracy, reliability, and durability of acceptable monitoring systems, as provided in COMAR 26.11.31, and is producing data.
- (3) The Permittee shall comply with the CEM Data Reporting Requirements of COMAR 26.11.01.11E as follows:
 - (a) All test results shall be reported in a format approved by the Department.
 - (b) Certification testing shall be repeated when the Department determines that the CEM data may not meet performance specifications because of component replacement or other conditions that affect the quality of generated data.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(c) A quarterly summary report shall be submitted to the Department not later than 30 days following each calendar quarter. The report shall be in a format approved by the Department, and shall include the following:

- (i) The cause, time periods, and magnitude of all emissions which exceed the applicable emission standards;
- (ii) The source downtime including the time and date of the beginning and end of each downtime period and whether the source downtime was planned or unplanned;
- (iii) The time periods and cause of all CEM downtime including records of any repairs, adjustments, or maintenance that may affect the ability of the CEM to meet performance specifications of emission data;
- (iv) Quarterly totals of excess emissions, installation downtime, and CEM downtime during the calendar quarter;
- (v) Quarterly quality assurance activities;
- (vi) Daily calibration activities that include reference values, actual values, absolute or percent of span differences, and drift status; and
- (vii) Other information required by the Department that is determined to be necessary to evaluate the data, to ensure that compliance is achieved, or to determine the applicability of this regulation.

(d) All information required by this regulation to be reported to the Department shall be retained and made available for review by the Department for a minimum of 2 years from the time the report is submitted."

(4) The Permittee must report orally or by electronic or facsimile transmission to the U.S. EPA and MDE, no later than 24 hours after the Permittee knew or should have known of any violation of the District Court Consent Decree, any permit regulations, or any event that may pose an immediate threat to the public health or welfare or the environment.

(5) The Permittee shall submit within 30 days following each January 1st and July 1st a semi-annual report to the U.S. EPA for the immediately preceding half-calendar year period. This report shall:

- (a) Identify any and all dates on which the Permittee has installed, or describe the progress of installation of, each ultra-low NO_x burner required for NO_x control, emission limits, CEMS, and monitoring requirements, and describe any problems encountered or anticipated during such installation, together with implemented or proposed solutions;
- (b) Provide all CEMS data collected for each Boiler #1 through #4 including an explanation of any periods of CEMS downtime together with any missing data for which American Sugar applied missing data substitution procedures, under Section VI.B of the Consent Order.
- (c) Demonstrate compliance with all applicable 30-day rolling average emission limits in Section V of the District Court Consent Decree.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(d) Describe the status of any operation and maintenance work relating to activities required under the District Court Consent Decree.

[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

E. Operational Limitations

(1) The Permittee shall operate the boilers such that the combined hours of operation for Boilers #1 through #4 do not exceed 20,220 hours in any consecutive 12-month period. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(12) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(2) In accordance with COMAR 26.11.09.06B(2), particulate matter emissions from the stack services Boilers #1 through #4 shall not exceed 0.020 grains per SCFD (corrected to 50% excess oxygen). **[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(3) In order to meet the 0.020 grains per SCFD (corrected to 50% excess oxygen) particulate matter emissions limit of COMAR 26.11.09.06B(2), the Permittee shall:

(a) Use only fuel oil (No. 2 or No. 6) in Boilers #1 through #4 with an ash content weight percent that will not cause total particulate matter emissions from the single powerhouse stack to exceed 0.020 grains per SCFD (corrected to 50% excess oxygen);

(b) Use natural gas and fuel oil (No. 2 or No. 6) in separate operating boilers that will not cause total particulate matter emissions from the single powerhouse stack to exceed 0.020 grains per SCFD (corrected to 50% excess oxygen); or

(c) Install a dust collector device designed to meet the 0.020 grains per SCFD (corrected to 50% excess oxygen) particulate matter emissions limit per COMAR 26.11.09.06B(1)(a).

[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]

(4) The Permittee shall design and operate the ultra-low NO_x burners on Boilers 1-4 and the low NO_x burner on Boiler 6 to meet the emission rate of 500 lbs./day (or 624 lbs./day, when appropriate) on a 30-day rolling average. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Sections V(11)(a) & V(10)(d) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

proposed in a letter to the EPA dated March 14, 2014 and approved by the EPA in a letter on April 2, 2014.]

(5) The primary combined NO_x emission limit that applies to the operation of boilers 1-4 and 6 is 500 lbs./day, calculated on a 30-day rolling average as described in the Order Modifying Consent Decree. This limit applies at all times, except in the circumstances described below when the limit of 624 lbs./day applies.

(a) Any day in which:

- i. Boiler 6 operates at any point in time;
- ii. Boiler 6 operates in conjunction with any of the CE boilers; or
- iii. Boiler 6 does not operate and only three (3) of the CE boilers operate would count toward the 500 lbs./day 30 day rolling average.

(b) If there are seven calendar days within a 30-day period in which Boiler 6 does not operate and each of the four CE boilers operates for some period of time in that calendar day, then the combined NO_x emission limit is 624 lbs./day. The seven days do not need to be consecutive.

(c) ASR will calculate the 30-day rolling average each day. If all four CE boilers operated for six days or less within the previous 30 calendar day period, the limit of 500 lbs./day applies. If all four CE boilers operated seven days or more during the previous 30-calendar day period, the limit of 624 lbs./day applies.

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(a) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]

(6) The Permittee shall continuously operate the NO_x control technology at all times of boiler operation. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(b) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(7) The total combined NO_x emissions from Boilers 1-4 & 6 in any consecutive 12-month period shall not exceed 60 tons. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(13) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(8) The total combined NO_x emissions from Boilers 1-4 & 6 in any calendar month shall not exceed 6.0 tons. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(14) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

Compliance Demonstration.

(1) The Permittee shall maintain electronically for at least five (5) years, and shall make available to the Department upon request, records of the following information:

(a) Monthly fuel oil (No. 2 or No. 6) usage in gallons per month and the total fuel usage (No. 2 or No. 6) for the previous rolling 12-month period.

[Reference: MDE Permit to Construct 510-5-1444 through 5-1447(August 28, 2014)]

(b) To comply with the annual emissions cap - the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the total amount of NO_x emissions for the current month and the previous eleven months. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(20) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(c) To comply with the monthly emissions cap - the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the amount of NO_x emissions for each operating day during the month. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(21) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(d) All stack emissions test documents. **[Reference: MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

(2) To comply with the limit on combined total hours of operation for Boilers #1 through #4, the Permittee shall maintain electronically for at least five (5) years, and shall make available to the Department upon request, monitoring records of the hours of operation of each boiler. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(19) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014)]**

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Emission Units: C6

Fuel burning equipment.

C6 – One (1) Babcock and Wilcox boiler rated at 300 MMBtu/hr. firing natural gas and equipped with a low NO_x burner and flue gas recirculation. (MDE Reg. No. 510-0314-5-1476)

Background

On January 18, 2013, a permit to construct was issued for the addition of an Ultra-Low NO_x Burner (ULNB) to Boiler 6. The addition of this burner is mandated by a District Court Consent Decree with the EPA (Civil Action No. JBK-12-1048). Also, the Permit to Construct included the re-rate of Boiler 6 from 249 MMBtu/hr. to 300 MMBtu/hr. and to limit the fuel use in Boiler 6 to natural gas only.

Note: Per the District Court Consent Decree modified by the District Court Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014, ASR does not need to install a ULNB on Boiler 6.

A Permit to Construct was issued on August 18, 2014, to incorporate the changes from the District Court Order Modifying Consent Decree dated August 5, 2013.

40 CFR 60, Subpart Db - Standards Of Performance For Industrial-Commercial-Institutional Steam Generating Units:

This regulation applies to Boiler #6 because the boiler was constructed after June 19, 1984, and has a heat input capacity greater than 100 MMBtu/hr. (40 CFR §60.40b(a)). While the addition of the ULNB does not meet the definition of "modification" found in 40 CFR §60.2, the re-rating of Boiler #6 from 249 MMBtu/hr. to 300 MMBtu/hr. does meet this definition. The definition of a modification indicates that the emissions must increase or that a pollutant will be emitted after the modification that was not emitted prior to the modification.

Boiler #6 is exempt from SO₂ requirements in this regulation per §60.42b(k)(2).

40 CFR 63, Subpart DDDDD - National Emission Standards For Hazardous Air Pollutants For Industrial, Commercial, And Institutional Boilers And Process Heaters:

This regulation does not apply because the facility is not a major source of Hazardous Air Pollutants (40 CFR §63.7485).

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

40 CFR 63, Subpart JJJJJJ - National Emission Standards For Hazardous Air Pollutants For Industrial, Commercial, And Institutional Boilers Area Sources:

This boiler is exempt from this regulation because it will be burning natural gas only. Gas fired boilers are defined in 40 CFR §63.11237 and exempted in 40 CFR §63.11195(e).

Compliance Status

During the 2022 full compliance report, Boiler #6 was operating on natural gas. NSPS Subpart Db – Semiannual report was received for the period Jan 2022 the June 2022. Boiler #6 operated on natural gas only. The 30-day average NO_x rate was between 0.033 – 0.082 lb./MMBtu. There were no exceedances to the NO_x emission rate during this period. The unit passed the daily calibration every day of the reporting period. There were no issues with calibration drift. CEMs downtime report shows 13 hrs. during this period over 6 different days (due to CEM maintenance). The most recent RATA was conducted April 7, 2022. Tuning activities were performed on Boiler #6 during March 22 and April 1, 2022, by B&W and Rockwell after the conclusion of the commissioning of a new Combustion Control System. EPA Consent Order Reporting Period (July 1, 2022, thru Dec 31, 2022) stated the following: **C6**: experienced a total downtime of 17 hours in the reporting period out of a total operating time of 1770 hours.

Applicable Standards/Limits:

A. Control of Visible Emissions

COMAR 26.11.09.05A - Visible Emissions

“(2) Areas III and IV₂. In Areas III and IV, a person may not cause or permit the discharge of emissions from any fuel burning equipment, other than water in an uncombined form, which is visible to human observers except that, for the purpose of demonstrating compliance using COM data, emissions that are visible to a human observer are those that are equal to or greater than 10 percent opacity.

(3) Exceptions. “Section A(1) and (2) of this **regulation** do not apply to emissions during load changing, soot blowing, startup, or adjustments or occasional cleaning of control equipment if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any sixty-minute period.”

Compliance Demonstration.

The Permittee shall report, in accordance with requirements under COMAR 26.11.01.07, occurrences of excess emissions to the Compliance Program of the Air and Radiation Administration.

**AMERICAN SUGAR REFINING, INC.
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PERMIT NO. 24-510-0314
 PART 70 OPERATING PERMIT FACT SHEET**

B. Control of Nitrogen Oxides

(1) **COMAR 26.11.09.08B(1)(a)**, Control of NO_x Emissions for Major Stationary Sources - General Requirements and Conditions. "Emission Standards and Requirements. A person who owns or operates an installation that causes NO_x emissions subject to this regulation is in compliance with this regulation if the person establishes compliance with the emissions standards in §B(1)(c) of this regulation."

(2) **COMAR 26.11.09.08B(1)(c)**, Control of NO_x Emissions for Major Stationary Sources – General Requirements and Conditions. "Emission Standards in Pounds of NO_x per Million Btu of heat input."

Fuel	Tangential- Fired	Wall-Fired
Gas only	0.20	0.20
Gas/Oil	0.25	0.25
Coal (dry bottom)	0.38	0.38
Coal (wet bottom)	1.00	1.0

(3) **COMAR 26.11.09.08B(2)(a)(i) and (b), (c), and (d)**, Control of NO_x Emissions for Major Stationary Sources – Demonstration of Compliance.

(a) "A person subject to a NO_x emission standard in this regulation shall demonstrate compliance as follows:

(i) For installations equipped with a CEM, compliance with the NO_x emissions standards in this regulation shall be established using CEM data; or"

(ii) *Not applicable.*

(b) "CEMs shall be certified in accordance with 40 CFR Part 60, Appendix B, or Part 75, Appendix A."

(c) "CEMs shall meet the quality assurance criteria in 40 CFR Part 60, Appendix F, or, for sources subject to Title IV of the Clean Air Act (Acid Rain), the quality assurance criteria in 40 CFR Part 75, Appendix B."

(d) "Except as otherwise established by the Department and approved by the EPA, for a person who establishes compliance with the NO_x emissions standards in this regulation using a CEM, compliance shall be determined as 30-day rolling averages."

(e) *Not applicable.*

(4) **COMAR 26.11.09.08B(5) - Operator Training**.

(a) "For purposes of this regulation, the equipment operator to be trained may be the person who maintains the equipment and makes the necessary adjustments for efficient operation."

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

(b) The operator training course sponsored by the Department shall include an in-house training course that is approved by the Department.”

(5) **COMAR 26.11.09.08C(3)**, Requirements for Fuel-Burning Equipment with a Rated Heat Input Capacity of 250 Million Btu Per Hour or Greater. “A person who owns or operates fuel burning equipment with a rated heat input capacity of 250 Million Btu per hour or greater shall install, operate, calibrate, and maintain a certified NOx CEM or an alternative NOx monitoring method approved by the Department and the EPA on each installation.”

(6) The Permittee shall design and operate the ultra-low NOx burners on Boilers 1-4 and the low NOx burner on Boiler 6 to meet the emission rate of 500 lbs./day (or 624 lbs./day, when appropriate) on a 30-day rolling average. [Reference: **District Court Consent Decree, Civil Action No. JKB-12-1408, Sections V(11)(a) & V(10)(d) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]**

(7) The primary combined NOx emission limit that applies to the operation of boilers 1-4 and 6 is 500 lbs./day, calculated on a 30-day rolling average as described in the District Court Consent Decree. This limit applies at all times, except in the circumstances described below when the limit of 624 lbs./day applies.

(a) Any day in which:

(1) Boiler #6 operates at any point in time;
(2) Boiler #6 operates in conjunction with any of the CE boilers; or (3) Boiler #6 does not operate and only three (3) of the CE boilers operate would count toward the 500 lbs./day 30 day rolling average.

(b) If there are seven calendar days within a 30-day period in which Boiler #6 does not operate and each of the four CE boilers operates for some period of time in that calendar day, then the combined NOx emission limit is 624 lbs./day. The seven days do not need to be consecutive.

(c) ASR will calculate the 30-rolling average each day. If all four CE boilers operated for six days or less within the previous 30 calendar day period, the limit of 500 lbs./day applies. If all four CE boilers operated seven days or more during the previous 30-calendar day period, the limit of 624 lbs./day applies.

[Reference: **District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(a) & MDE Permit to Construct 510-5-1444 through 5-1447 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]

(8) The total combined NO_x emissions from Boilers #1-#4 & #6 in any consecutive 12-month period shall not exceed 60 tons. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(13) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]

(9) The total combined NO_x emissions from Boilers #1-#4 & 6 in any calendar month shall not exceed 6.0 tons. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(14) & MDE Permit to Construct 510-5-1476 (August 28, 2014)]

(10) The Permittee shall not cause to be discharged into the atmosphere any gases that contain NO_x (expressed as NO₂) in excess of 86 ng/J (0.20 lb./MMBtu) heat input. This limit applies at all times including periods of startup, shutdown, or malfunction. Compliance with this emission limit is determined on a 30-day rolling average basis. [Reference: 40 CFR §60.44b(l)(1), 40 CFR §60.44b(h), 40 CFR §60.44b(i), and 40 CFR §60.46b(a) & MDE Permit to Construct 510-5-1476 (August 28, 2014)]

(11) The Permittee shall continuously operate the low NO_x burner at all times of boiler operation. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(11)(b) & MDE Permit to Construct 510-5-1476 (August 28, 2014). Modified by the Order Modifying Consent Decree dated August 5, 2013, and the emission rates proposed in a letter to the EPA dated March 14, 2014, and approved by the EPA in a letter on April 2, 2014.]

(12) COMAR 26.11.40-NO_x Ozone Season Emission Caps for Non-trading Large NO_x Units.

.02 Applicability.

"A. The owner or operator of a non-trading large NO_x unit, that is not a unit subject to the federal Cross State Air Pollution Rule NO_x Ozone Season Group 2 Trading Program established under 40 CFR Part 97, Subpart EEEEE, shall comply with the ozone season NO_x emission limitation, monitoring, record keeping, and reporting requirements for ozone season emissions of NO_x set forth in this chapter. *(This is superseded by Group 3 Subpart GGGGG published April 30, 2021, effective June 29, 2021).*

**AMERICAN SUGAR REFINING, INC.
 1100 KEY HIGHWAY EAST
 BALTIMORE, MD 21230
 PERMIT NO. 24-510-0314
 PART 70 OPERATING PERMIT FACT SHEET**

B. The requirements of this chapter apply to a person who owns or operates a non-trading large NOx unit located at the affected sources in §C of this regulation.

C. Affected Sources and Units. (1) American Sugar Unit No. C6.”

.03 NOx Ozone Season Emission Caps.

A. The total combined NOx ozone season emissions for all non-trading large NOx units subject to this chapter may not exceed 1013 tons in accordance with the 40 CFR Part 97, Subpart E, Appendix C.

B. NOx Ozone Season Emission Caps.

(1) The total combined ozone season NOx emissions from all the affected units at an affected source as identified in Regulation .02C of this chapter may not exceed the NOx ozone season emission caps in §B(2) of this regulation.

(2) Table – NOx Ozone Season Emission Caps.

Affected Sources	NOx Ozone Season Emission Caps Beginning May 1, 2018
American Sugar	24 tons

Compliance Demonstration

(1) The Permittee shall conduct the performance test as required under §60.8 using the continuous system for monitoring NOx under §60.48b to determine compliance with the NOx emission limit as follows:

Following the date on which the initial performance test is completed or is required to be completed under §60.8, whichever date comes first, the Permittee shall determine compliance with the NOx standards under §60.44b on a continuous basis through the use of a 30-day rolling average emission rate. A new 30-day rolling average emission rate is calculated each steam generating unit operating day as the average of all of the hourly NOx emission data for the preceding 30 steam generating unit operating days.

(2) Repeat certification testing when the Department determines that the CEM data may not meet performance specifications because of component replacement or other conditions that affect the opacity of generated data.

[Reference: 40 CFR §60.46b(c) and 40 CFR §60.46b(e)(1) and (3) & COMAR 26.11.01.11E(2)(b)]

(1) At a point in the stack prior to a point at which boiler flue gas combines with flue gas from any other boiler, American Sugar shall install and make operational, a NOx continuous emissions monitoring system (CEMS) to monitor NOx emissions in accordance with the requirements of 40 CFR Part 60. The CEMS shall be installed and operated in accordance with the plan approved by the Department and EPA under the provisions of COMAR 26.11.01.11B(1)(a).

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(15) and COMAR 26.11.01.11B(1)(a) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014) & COMAR 26.11.40.04A(1)]

(2) The Permittee shall calibrate, maintain, and operate a continuous emissions monitoring system, and record the output of the system for measuring NO_x emissions in accordance with 40 CFR §60.48b(b)(1).

(3) Each CEMs shall be installed, certified, calibrated, maintained, and operated in accordance with the applicable requirements of 40 CFR Part 60, and any requirements established by applicable Maryland regulations. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(17) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(4) The Permittee shall install, calibrate, maintain, and operate CEMS for measuring NO_x and O₂ (or CO₂) emissions discharged to the atmosphere, and shall record the output of the system. **[Reference: 40 CFR §60.48b(b)(1)]**

(5) The procedures under §60.13 shall be followed for installation, evaluation, and operation of the continuous monitoring system. The span value for NO_x is 500 ppm. **[Reference: 40 CFR §60.48b(e)(2)(i)]**

(6) The CEMS shall monitor and record the applicable NO_x Emission Rate for Boiler #6 to demonstrate compliance with the NO_x emission rates and shall be continuously operated, except during CEMS breakdowns, repairs, calibration checks, and zero span adjustments. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(16) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(7) The CEMS shall be operated, and data recorded during all periods of operation of Boiler #6 except for CEMS breakdowns and repairs. Data is recorded during calibration checks, and zero and span adjustments. **[Reference: 40 CFR §60.48b(c)]**

(8) The Permittee shall measure all emissions of NO_x with the CEMS. During any period of time when any CEMS is inoperable or not measuring NO_x emissions from Boiler 6, the Permittee shall apply the missing data substitution procedures in 40 CFR Part 75, Subpart D. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(18) and 40 CFR §60.48b(f) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(9) To comply with the annual emission cap, the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the total amount of NO_x emissions for the current month and the previous eleven months.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(20) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]

(10) To comply with the monthly emissions cap, the Permittee shall convert the monitored CEMS data to a mass emission (tons) and sum the amount of NO_x emissions for each Operating Day during the month. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(21) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

(11) The 1-hour average NO_x emission rates measured by the continuous NO_x monitor required by 40 CFR §60.48b(b) and required under §60.13(h) shall be expressed in ng/J or lb./MMBtu heat input and shall be used to calculate the average emission rates under §60.44b. The 1-hour averages shall be calculated using the data points required under §60.13(h)(2). **[Reference: 40 CFR §60.48b(d)]**

(12) The Permittee shall use the alternative measurement method approved by the Department and the EPA if the Permittee is unable to obtain emissions data from CEMS because of a malfunction of the CEMS for more than 2 hours in duration. **[Reference: COMAR 26.11.01.11B(4)]**

(13) The Permittee shall ensure that the CEMS used to monitor a gas concentration shall meet the quality assurance criteria of 40 CFR Part 60, Appendix F, as amended, which is incorporated by reference, or, if applicable, the quality assurance criteria of 40 CFR Part 75, Appendix B, as amended. **[Reference: COMAR 26.11.01.11C]**

(14) The CEM used to monitor a gas concentration shall record not less than four equally spaced data points per hour and automatically reduce data in terms of averaging times consistent with the applicable emission standard. **[Reference: COMAR 26.11.01.11D(2)]**

The Permittee shall maintain records for at least two (2) years of the following information for Boiler 6 for each operating day.

- (a) Calendar date;
- (b) The average hourly NO_x emission rates (expressed as NO₂) (ng/J) or lb./MMBtu heat input) measured or predicted;
- (c) The 30-day average NO_x emission rates (ng/J or lb./MMBtu heat input) calculated at the end of each Boiler 6 operating day from the measured or predicted hourly nitrogen oxide emission rates for the preceding 30 Boiler 6 operating days;

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

- (d) Identification of the Boiler 6 operating days when the calculated 30-day average NO_x emission rates are in excess of the NO_x emissions standards under §60.44b, with the reasons for such excess emissions as well as a description of corrective actions taken;
- (e) Identification of the Boiler 6 operating days for which pollutant data have not been obtained, including reasons for not obtaining sufficient data and a description of corrective actions taken;
- (f) Identification of the times when emission data have been excluded from the calculation of average emission rates and the reasons for excluding data;
- (g) Identification of the "F" factor used for calculations, method of determination, and type of fuel combusted;
- (h) Identification of the times when the pollutant concentration exceeded full span of the CEMS;
- (i) Description of any modifications to the CEMS that could affect the ability of the CEMS to comply with Performance Specification 2 or 3 in appendix B of 40 CFR Part 60; and
- (j) Results of daily CEMS drift tests and quarterly accuracy assessments as required under appendix F, Procedure 1 of 40 CFR Part 60.

[Reference: 40 CFR §60.49b(g), (i) and (o) & COMAR 26.11.40.04A(2)]

(2) The Permittee shall maintain for at least five (5) years, and shall make available to the Department upon request, records of the following information:

- (a) Annual fuel use records for Boiler #6;
- (b) Log of operation and maintenance of the CEMs including duration and reason of any malfunctions; and
- (c) Records of operator training.

[Reference: MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]

(1) The Permittee must submit excess emission reports for any excess emissions that occurred during the reporting period. The Permittee must maintain these records on site for at least two (2) years. **[Reference: 40 CFR §60.49b(h)(2)(i) and (o)]**

(2) The Permittee must report orally or by electronic or facsimile transmission to the U.S. EPA and MDE, no later than 24 hours after the Permittee knew or should have known of any violation of the District Court Consent Decree, any permit regulations, or any event that may pose an immediate threat to the public health or welfare of the environment. **[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section IX(40) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(3) **COMAR 26.11.09.08K - Reporting Requirements.**

(a) "When demonstration of compliance with the NO_x emission standards in this regulation is based on CEM data, quarterly emission reports shall be submitted to the Department on or before the thirtieth day of the month following the end of each calendar quarter.

(b) When compliance with this regulation is demonstrated by a stack test, the results of the stack tests required by this regulation shall be submitted to the Department within 45 days after completion of the test.

(c) A person subject to this regulation shall maintain annual fuel use records on site for not less than 3 years and make these records available to the Department upon request."

(4) The Permittee must report to the Department, by telephone, any CEM system downtime that lasts or is expected to last more than 24 hours, by 10 a.m. of the first regular business day following the breakdown. The Permittee must also notify the Department, by telephone, when an out-of-service CEMS is back in operation. **[Reference: COMAR 26.11.01.11E(1)(a) and (b)]**

(5) The Permittee shall comply with the CEM system downtime reporting requirements of COMAR 26.11.01.11E:

(a) All CEM system downtime that lasts or is expected to last more than 24 hours shall be reported to the Department by telephone before 10 a.m. of the first regular business day following the breakdown.

(b) The system breakdown report required by COMAR 26.11.01.11E(1)(a) shall include the reasons, if known, for the breakdown and the estimated period of time that the CEMS will be down. The Permittee shall notify the Department by telephone when an out-of-service CEM is back in operation and producing valid data. **[Reference: COMAR 26.11.01.11E(1)]**

(6) The Permittee shall submit to the Department quarterly, a CEMs summary report not later than 30 days following each calendar quarter to demonstrate compliance with the NO_x emissions limits. The report shall include the following information:

(a) The cause, time periods, and magnitude of all emissions which exceed the applicable emission standards;

(b) The source downtime including the time and date of the beginning and end of each downtime period and whether the source downtime was planned or unplanned;

(c) The time periods and cause of all CEM downtime including records of any repairs, adjustments, or maintenance that may affect the ability of the CEM to meet performance specifications of emission data;

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

- (d) Quarterly totals of excess emissions, installation downtime, and CEM downtime during the calendar quarter;
- (e) Quarterly quality assurance activities;
- (f) Daily calibration activities that include reference values, actual values, absolute or percent of span differences, and drift status; and
- (g) Other information required by the Department that is determined to be necessary to evaluate the data, to ensure that compliance is achieved, or to determine the applicability of this regulation.

[Reference: COMAR 26.11.01.11E(2)(c) & COMAR 26.11.40.04B]

(7) The Permittee shall submit within 30 days following each January 1st and July 1st, a semi-annual report to the U.S. EPA for the immediately preceding half-calendar year period. This report shall:

- (a) Identify any and all dates on which the Permittee has installed, or describe the progress of installation of the low NO_x burner required for NO_x control, emission limits, CEMs, and monitoring requirements and describe any problems encountered or anticipated during such installation, together with implemented or proposed solutions;
- (b) Provide all CEMS data collected for Boiler 6 including an explanation of any periods of CEMS downtime together with any missing data for which the Permittee applied and missing data substitution procedures under Section VI.B of the District Court Consent Decree;
- (c) Demonstrate compliance with all applicable 30-day rolling average emission limits in Section V of the District Court Consent Decree; and
- (d) Describe the status of any operation and maintenance work relating to activities under the District Court Consent Decree.

[Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section IX(38) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014) & COMAR 26.11.40.04A(2)]

C. Operational Limitations

(1) The Permittee shall burn only natural gas in this boiler. **[Reference: MDE Permit to Construct 510-5-1476 (August 28, 2014)]**

(2) The Permittee must use gaseous fuels with potential SO₂ emissions rates of 26 ng/J (0.060 lb./MMBtu) or less and shall not use post-combustion technology to reduce SO₂ or PM emissions. The Permittee must meet these requirements in order to not be required to install or operate a COMS. **[Reference: 40 CFR §60.48b(j)(2) & MDE Permit to Construct 510-5-1476 (August 28, 2014)]**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Compliance Demonstration.

The Permittee shall install meters to record the hours of operation of this boiler and shall maintain the monitoring records in an electronic format for at least five (5) years. [Reference: District Court Consent Decree, Civil Action No. JKB-12-1408, Section V(19) & MDE Permit to Construct No. 510-0314-5-1476 (August 28, 2014)]

The Permittee shall record and maintain records of the amounts of natural gas combusted during each day and calculate the annual capacity factor for natural gas for the reporting period. The annual capacity factor is determined on a 12-month rolling average basis with a new annual capacity factor calculated at the end of each calendar month. The records must be maintained on-site for at least two (2) years and be made available to the Department upon request.

[Reference: 40 CFR §60.49b(d)(1) and (o)]

Emission Units: R29-1

R29-1 – Raw Sugar Unloading and Conveying (MDE Reg. No. 6-2019).

A Permit to Construct issued August 5, 2021, for the installation of the Additional sugar conveyance at the Old Raw Sugar Shed [To provide additional storage capacity, two schemes were installed: (1) A traveling conveyor from the shed's shuttle RSS-1 to feed and discharge directly into the storage barge – at a maximum throughput rate of 1,200,000 lb./hr.; and (2) a clam shell loader to scoop raw sugar from the barge for placement in the Old Raw Sugar Shed – at a maximum throughput rate of 250,000 lbs./hr.]

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. A ship was being unloaded at the dock. There were no fugitive dust emissions observed from that unloading process. A three-alarm fire broke out at the raw sugar shed on April 20, 2021. The raw sugar shed burned down and then collapsed. The debris from the fire has been removed from the site and the area where the shed previously stood has been cleared as they prepare to add a new sugar shed. A Construction Permit was issued for conveyance equipment to transfer raw sugar from the barge to a different storage area or a temporary holding barge for the raw sugar. A Report of Excess Emissions due to the fire was received at the Department April 28, 2021.

Applicable Standards/Limits:

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2)“In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers.”

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and
- (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. **[Reference: COMAR 26.11.03.06C]**

COMAR 26.11.01.07C – Report of Excess Emissions

"(1) In the case of any occurrence of excess emissions, expected to last or actually lasting for 1 hour or more, from any installation required by COMAR 26.11.02.13 to obtain a State permit to operate, the owner or operator shall report the onset and shall report the termination of the occurrence to the Department by telephone.

- (2) Telephone reports of excess emissions shall include the following information:
 - (a) The identity of the installation and the person reporting;
 - (b) The nature or characteristics of the emissions (for example, hydrocarbons, fluorides);
 - (c) The time of occurrence of the onset of the excess emissions and the actual or expected duration of the occurrence; and
 - (d) The actual or probable cause of the excess emissions."

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

B. Control of Particulate Matter

COMAR 26.11.06.03C(1) - Particulate Matter from Unconfined Sources.

“A person may not cause or permit emissions from an unconfined source without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, when appropriate as determined by the Department, the installation and use of hoods, fans, and dust collectors to enclose, capture, and vent emissions. In making this determination, the Department shall consider technological feasibility, practicality, economic impact, and the environmental consequences of the decision.”

Compliance Demonstration

The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for equipment installed to minimize dusting; and (2) a log with records of the dates and description of maintenance activity performed.

[Reference: COMAR 26.11.03.06C]

Emission Units: **R29-3, 4; S7B-2; S7-12; S7-13, & S7-14**

R29-3: Melter Feed

R29-4: Diatomite Fugitives

S7B-2: Bin Tower Rejects Box (MDE Reg. No. 8-0212)

S7-12: Maltodex Supersack Unloading System (MDE Reg. No. 8-0266)

S7-13: Remelt Shredder Fugitives

S7-14: Magnets Tailings Fugitives (MDE Reg. No. 8-0223)

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Monthly inspections of visible emission sources have been conducted and the results recorded. Records are kept for at least 5 years. A preventative maintenance plan is in effect for the control equipment with a time schedule associated with it.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and
- (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. **[Reference: COMAR 26.11.03.06C]**

B. Control of Particulate Matter

COMAR 26.11.06.03B(2) - Particulate Matter from Confined Sources. "(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm)."

Compliance Demonstration

The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for equipment installed to minimize dusting; and (2) a log with records of the dates and description of maintenance activity performed. [Reference: COMAR 26.11.03.06C]

Emission Units: D28-1; D10-1; D10-2; D10-3

Carbonation System:

D28-1: Lime silo equipped with a baghouse (RP-C-1). (MDE Reg. No. 8-0301)

D10-1: Saturator 1 equipped with a demister and a scrubber (RP-C-2). (MDE Reg. No. 8-0301)

D10-2: Saturator 2 equipped with a demister and a scrubber (RP-C-3). (MDE Reg. No. 8-0301)

D10-3: Saturator 3 equipped with a demister and a scrubber (RP-C-4). (MDE Reg. No. 8-0301)

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Monthly inspections of visible emission sources have been conducted and the results recorded. Records are kept for at least 5 years. A preventative maintenance plan is in effect for the control equipment with a time schedule associated with it.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and
- (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. **[Reference: COMAR 26.11.03.06C]**

B. Control of Particulate Matter

COMAR 26.11.06.03B(2) - Particulate Matter from Confined Sources. "(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm)."

Compliance Demonstration

The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. **[Reference: COMAR 26.11.03.06]**

The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:

- (1) a copy of the preventative maintenance plan for each dust collector;
- (2) records of the dust collector malfunction, and the corrective action taken to bring it back into proper operation; and
- (3) a log with records of the dates and description of maintenance activity performed.

[Reference: COMAR 26.11.03.06C]

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Emission Units: D2-1 & U5-1

D2-1: Mud Loading (MDE Reg. No.8-0301).

U5-1: Cooling Tower (MDE Reg. No. 8-0383).

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Monthly inspections of visible emission sources have been conducted and the results recorded. Records are kept for at least 5 years. A preventative maintenance plan is in effect for the control equipment with a time schedule associated with it.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. **[Reference: COMAR 26.11.03.06C]**

B. Control of Particulate Matter

COMAR 26.11.06.03C(1) - Particulate Matter from Unconfined Sources.

"A person may not cause or permit emissions from an unconfined source without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, when appropriate as determined by the Department, the installation and use of hoods, fans, and dust collectors to enclose, capture, and vent emissions. In making this determination, the Department shall consider technological feasibility, practicality, economic impact, and the environmental consequences of the decision."

Compliance Demonstration

The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for equipment installed to minimize dusting; and (2) a log with records of the dates and description of maintenance activity performed. **[Reference: COMAR 26.11.03.06C]**

Emission Units: S5-1 thru S5-6; S5-8A thru S5-8G; S7A-1; S7-5 thru S7-7; S7-8A thru S7-8D; S7-10A & S7-10B; S7B-1, S7-11A thru S7-11C.

S5-1: Scrap Melter 1 equipped with a rotoclone scrubber(RP-C-10). (MDE Reg. No. 8-0226)

S5-2: Scrap Melter 2 (MDE Reg. No. 8-0382)

S5-3: Remelt Screw Conveyors (MDE Reg. No. 8-0382)

S5-4: Invert system controlled by a rotoclone scrubber (RP-C-10). This system consists of the following equipment:

[S5-4A – Invert Cloudy Tank (5-3-16); S5-4B – Invert Precoat Tank (5-3-17); S5-4C – Sucrose Cloudy Tank (5-3-13); S5-4D – Sucrose Precoat Tank (5-3-14)]

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

S5-4E – Clear Sucrose Tank (5-3-12); S5-4F – Clear Invert Tank (5-3-15)].
(MDE Reg. No. 6-2022)

S5-5: Caustic Fugitives associated with the invert system. (MDE Reg. No. 6-2022)

S5-6: Soft Sugar Shredder. (MDE Reg. No. 6-2020)

S5-8A-B: Two (2) Dryers (Powdered Specialty Sugars) each equipped with a venturi scrubber (DW-1) (RP-C-33), (DW-2) (RP-C-34).

S5-8D: Liquid Sugar Cooler (Powdered Specialty Sugars) equipped with a Sly venturi scrubber (WS-1) (RP-C-35).

S5-8E: Three (3) Centrifugal Separators (Powdered Specialty Sugars) equipped with a Sly venturi scrubber (WS-1) (RP-C-36).

S5-8F: Washout Tanks and Beater controlled by a Rotoclone.

S5-8G: Packaging and Conveying Equipment controlled by a Sly venturi scrubber (WS-1) (RP-C-36).

(MDE Reg. No. 8-0332)

S1-1: FEECO Rotary sugar dryer equipped with an Entoleter vortex scrubber (RP-C-15) (MDE Reg. No. 0320)

S7A-1: Bulk Sugar Conveying System equipped with a scrubber (RP-C-25).

This system consists of the following equipment:

[S7A-RE1 – Bucket Elevator RE-1; S7A-XE1 – Bucket Elevator XE-1; S7A-XRS1 – Bucket Elevator XRS-1; S7A-UE1 – Bucket Elevator UE-1; S7A-UE2A – Bucket Elevator UE-2A; S7A-UE2B – Bucket Elevator UE-2B; S7A-RE2 – Bucket Elevator RE-2; S7A-U1 – Storage Bin U1; S7A-U2 – Storage Bin U2; S7A-U3 – Storage Bin U3; S7A-U4 – Storage Bin U4; S7A-U5 – Storage Bin U5; S7A-U6 – Storage Bin U6; S7A-XF1 – Storage Bin XF1; S7A-XF2 – Storage Bin XF2; S7A-V1 – Storage Bin V1; S7A-V2 – Storage Bin V2; S7A-V3 – Storage Bin V3; S7A-V4 – Storage Bin V4; S7A-V5 – Storage Bin V5; S7A-V6 – Storage Bin V6; S7A-C1 – Storage Bin C1; S7A-F1 – Storage Bin F1; S7A-AR1 – Storage Bin AR1; S7A-AR2 – Storage Bin AR2; S7A-AR3 – Storage Bin AR3; S7A-AR4 – Storage Bin AR4; S7A-AR5 – Storage Bin AR5; S7A-AR6 – Storage Bin AR6; S7A-AR7 – Storage Bin AR7; S7A-AR8 – Storage Bin AR8, and S7A-RJX – Screw Conveyor Rejects Transfer]. (MDE Reg. No. 8-0212)

S7-5, S7-6, S7-7: Packaging Feed Tanks each equipped with a filter (RP-C-26, -27 & -28, respectively). (MDE Reg. No. 8-0265)

S7-8: Packaging Operations controlled by a rotoclone scrubber (7-6-1) (RP-C-29). This system consists of the following equipment:

[S7-8A: Fawema Packaging System; S7-8B: Paxall Packaging System; S7-8C: Clouds Packaging System, and S7-8D: Handi Pak System]. (MDE Reg. No. 8-0265)

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

S7-10: Packaging System controlled by a Wheelabrator dust collector (7-5-1) (RP-C-30).

[S7-10A: Hesser Bagging System; S7-10B: Supersack Unloading System]. (MDE Reg. No. 8-0265)

S7B-1: Bulk Loading System with an Entoleter scrubber (RP-C-31) and DCL UN800 Dust Collectors. (MDE Reg. No. 8-0223)

S7-11: Super-Sack Sugar Packaging Line controlled by Wheelabrator dust collectors.

[S7-11A: Thiele Supersack System; S7-11B: Tub Packaging Line controlled by Wheelabrator 7-5-2 (RP-C-30), and S7-11C: Simplex Packaging Line controlled by a Wheelabrator dust collector 6-5-1 (RP-C-12)]. (MDE Reg. No. 8-0287)

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Monthly inspections of visible emission sources have been conducted and the results recorded. Records are kept for at least 5 years. Preventative maintenance plans have been developed along with timeframes to inspect certain items. Verified that the exhaust gases: (1) from the specialty sugar process vent through the cyclonic separator and the venturi scrubber; (2) from the washout tanks vent through the rotoclone; (3) from the packing and conveying equipment vent through the rotoclone and the venturi scrubber.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

(a) The visible emissions are not greater than 40 percent opacity; and

(b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and
- (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. **[Reference: COMAR 26.11.03.06C]**

B. Control of Particulate Matter

COMAR 26.11.06.03B - Particulate Matter from Confined Sources.

“(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).”

COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction.

“A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:

- (1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.
- (2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.
- (3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.
- (4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

- (5) The paving of roadways and their maintenance in clean condition.
- (6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water."

Compliance Demonstration

(1)The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. **[Reference: COMAR 26.11.03.06C]**

(2) The exhaust gases from two liquid sugar dryers (VD1 and VD-2), the liquid sugar coolers (VC-1) and three centrifugal separators (SK-1, SK-2, and SK-3) shall be vented through the cyclonic separator and the venturi scrubber, when the specialty sugar refining process is operating.

(3) The exhaust gases from the washout tanks/beater shall be vented through the rotoclone scrubber when the specialty sugar refining process is operating.

(4) The exhaust gases from the packing and conveying equipment shall be vented through the rotoclone and the venturi scrubber when the specialty sugar refining process is operating.

[Reference: MDE Permit to Construct #510-8-0332 (July 10, 2003)].

The Permittee shall maintain records of the amount and type of specialty sugar produced each month for the specialty sugar refining process equipped with four venturi scrubbers shall be kept at the site for at least five (5) years and shall be made available to the Department upon request. **[Reference: MDE Permit to Construct #510-8-0332 (July 10, 2003)].**

The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:

- (a) a copy of the preventative maintenance plan for each dust collector;
 - (b) records of the dust collector malfunction, and the corrective action taken to bring it back into proper operation; and
 - (c) a log with records of the dates and description of maintenance activity performed. **[Reference: COMAR 26.11.03.06C]**
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AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Emission Units: **S6-4 thru S6-7.**

S6-4: BMA Granulator equipped with an Entoleter Scrubber (RP-C-11). (MDE Reg. No. 8-0115)

S6-5: Sugar Packaging Line and Conveying Systems controlled by a shared Wheelabrator dry filter (RP-C-12, RP-C-13, and RP-C-14). This line consists of the following equipment: [S6-5A: Remelt Shredder; S6-5B: Maltrin Tank; S6-5C: Sugar Tank; S6-5D: MFB Feeder; S6-5E : Sugar Feed to Mill 1; S6-5F: Sugar Feed to Mill 2; S6-5G: Sugar Feed to Mill 3; S6-5H: 6-5-1200 Receiver; S6-5I: UB-1 South Hood, and S6-5J: UB-1 Tail End]. (MDE Reg. No. 8-0222)

S6-6: Sugar Packaging Line and Conveying Systems controlled by a shared Wheelabrator dry filter (RP-C-12, RP-C-13, and RP-C-14). This line consists of the following equipment: [S6-6A: Oscillator; S6-6B: DSE-1 (9-25-10); S6-6C: US-2 Scroll, and S6-6D: UB-1 North]. (MDE Reg. No. 8-0296)

S6-7: Sugar Packaging Line and Conveying Systems controlled by a shared Wheelabrator dry filter (RP-C-12, RP-C-13, and RP-C-14). [S6-7A: Receiver 1300 2#; S6-7B: Old V. Bag Packaging System; S6-7C: Receiver 1250; S6-7D: Receiver 6-4-1300; S6-7E: 2# Poly Filler System; S6-7F: New V.B. Filler System; S6-7G: Old V.B. Filler System; S6-7H: Packet Grinder, and S6-7I: 1-4 10X Filler System]. (MDE Reg. No. 8-0225); [S6-7J: Bulkline (Super sack: 1-ton bag) Packaging Line]. (MDE Reg. No. 8-0409)

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Monthly inspections of visible emission sources have been conducted and the results recorded. Records are kept for at least 5 years. Preventative maintenance plans have been developed along with timeframes to inspect certain items.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

(a) The visible emissions are not greater than 40 percent opacity; and

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period.”

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and
- (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

[Reference: COMAR 26.11.03.06C]

The Permittee shall maintain for at least five (5) years and make available to the Department upon request: a record of the results of the monthly inspections and the log of inspection and maintenance; and a log with records of the dates and description of maintenance activities performed. **[Reference: COMAR**

26.11.03.06C & MDE Permit to Construct #510-0314-8-0409 (June 19, 2020)]
COMAR 26.11.01.07C – Report of Excess Emissions

“(1) In the case of any occurrence of excess emissions, expected to last or actually lasting for 1 hour or more, from any installation required by COMAR 26.11.02.13 to obtain a State permit to operate, the owner or operator shall report the onset and shall report the termination of the occurrence to the Department by telephone.

(2) Telephone reports of excess emissions shall include the following information:

- (a) The identity of the installation and the person reporting;
- (b) The nature or characteristics of the emissions (for example, hydrocarbons, fluorides);
- (c) The time of occurrence of the onset of the excess emissions and the actual or expected duration of the occurrence; and
- (d) The actual or probable cause of the excess emissions.”

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

B. Control of Particulate Matter

COMAR 26.11.06.03B - Particulate Matter from Confined Sources.

"(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm)."

COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction.

"A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:

- (1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.
- (2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.
- (3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.
- (4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.
- (5) The paving of roadways and their maintenance in clean condition.
- (6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water."

Compliance Demonstration

The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan. **[Reference: COMAR 26.11.03.06C]**

The exhaust gases from the packing and conveying equipment shall be vented through the rotoclone and the venturi scrubber when the specialty sugar refining process is operating.

The Permittee shall maintain records of the amount and type of specialty sugar produced each month for the specialty sugar refining process equipped with four venturi scrubbers shall be kept at the site for at least five (5) years and shall be made available to the Department upon request. **[Reference: MDE Permit to Construct #510-0314-8-0409 (June 19, 2020)].**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (a) a copy of the preventative maintenance plan for each dust collector; (b) records of the dust collector malfunctions and the corrective action taken to bring it back into proper operation; and (c) a log with records of the dates and description of maintenance activity performed. **[Reference: COMAR 26.11.03.06C]**

Emission Units: **S6-1, S6-1A, S6-2, S6-2A, S6-3, S6-3A, S6-8, & S6-9.**

S6-1: Sugar Mill 1 equipped with MAC dry filter (RP-C-16) (MDE Reg. No. 8-0209).

S6-1A: Starch Receiver 1 equipped with a dry filter (RP-C-17). (MDE Reg. No. 8-0209)

S6-2: Sugar Mill 2 equipped with MAC dry filter (RP-C-18) (MDE Reg. No. 8-0209).

S6-2A: Starch Receiver 2 equipped with a dry filter (RP-C-19). (MDE Reg. No. - 8-0209)

S6-3: Sugar Mill 3 equipped with MAC dry filter (RP-C-20) (MDE Reg. No. 8-0125).

S6-3A: Starch Receiver 3 equipped with a dry filter (RP-C-21). (MDE Reg. No. 8-0125)

S6-8: Sugar Pulverizer (Mill 7) equipped with a Mikropul baghouse (RP-C-24). (MDE Reg. No. 8-0266)

S6-9: Starch Bin equipped with a vent filter (RP-C-22). (MDE Reg. No. 8-0125)

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Monthly inspections of visible emission sources have been conducted and the results recorded. Records are kept for at least 5 years. Preventative maintenance plans have been developed along with timeframes to inspect certain items.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and
- (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

[Reference: COMAR 26.11.03.06C]

The Permittee shall maintain records of the results of the monthly inspections and the log of inspection and maintenance for at least five (5) years and make them available to the Department upon request. **[Reference: COMAR 26.11.03.06C]**

B. Control of Particulate Matter

COMAR 26.11.06.03B - Particulate Matter from Confined Sources.

"(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm)."

COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction.

"A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

- (1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.
- (2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.
- (3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.
- (4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.
- (5) The paving of roadways and their maintenance in clean condition.
- (6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water.”

Compliance Demonstration

The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan.

The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:

- (a) a copy of the preventative maintenance plan for each dust collector;
- (b) records of the dust collector malfunction, and the corrective action taken to bring it back into proper operation; and
- (c) a log with records of the dates and description of maintenance activity performed. [Reference: COMAR 26.11.03.06C]

Emission Units: **S5-7, S7-15, & S7-16.**

S5-7: Ten (10) Evaporation Pans (Pan 1 thru 9 and 11) (MDE Reg. No. 6-2021)

S7-15: Packaging Video Inkjet Printers (MDE Reg. No. 6-0218)

S7-16: Packaging Adhesive Fugitives (MDE Reg. No. 9-1298).

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Records of material usage of VOC containing products are kept on site showing the amount of adhesive, solvents and inks used, as well as the VOC content of each. This data is used to calculate VOC emissions for the Emissions Certification Report. Emission Certification Report FY2021 shows that the facility used two types of packaging adhesives: Hot melt glue (TS200) – 0.1% VOC content and cold glue (A1940) – 0.55% VOC content.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall report all occurrences of excess emissions to the Department. [**Reference: COMAR 26.11.01.07**].

B. Control of VOC Emissions

Video Inkjet Packaging Lines- S7-15 (MDE Reg. No. 6-2018)

COMAR 26.11.09.02I. - Good Operating Practices, Equipment Cleanup, and VOC Storage.

"(1) Applicability. The requirements in this section apply to a person who owns or operates an installation that is subject to any requirement in this chapter.

(2) Good Operating Practices.

- (a) A person who is subject to this section shall implement good operating practices to minimize VOC emissions into the atmosphere.
- (b) Good operating practices shall, at a minimum, include the following:
 - (i) Provisions for training of operators on practices, procedures, and maintenance requirements that are consistent with the equipment manufacturers' recommendations and the source's experience in operating the equipment, with the training to include proper procedures for maintenance of air pollution control equipment;
 - (ii) Maintenance of covers on containers and other vessels that contain VOC and VOC-containing materials when not in use;
 - (iii) Minimize spills of VOC-containing cleaning materials;
 - (iv) Convey VOC-containing cleaning materials from one location to another in closed containers or pipelines;
 - (v) Minimize VOC emissions from cleaning of storage, mixing, and conveying equipment;
 - (vi) As practical, scheduling of operations to minimize color or material changes when applying VOC coatings or other materials by spray gun;

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(vii) For spray gun applications of coatings, use of high-volume low pressure (HVLP) or other high efficiency application methods where practical; and
(viii) As practical, mixing or blending materials containing VOC in closed containers and taking preventive measures to minimize emissions for products that contain VOC.

(c) A person subject to this regulation shall:

(i) Establish good operating practices in writing;

(ii) Make the written operating practices available to the Department upon request; and

(iii) Display the good operating practices so that they are clearly visible to the operator or include them in operator training.

(3) Equipment Cleanup.

(a) A person subject to this section shall take all reasonable precautions to prevent or minimize the discharge of VOC into the atmosphere when cleaning process and coating application equipment, including containers, vessels, tanks, lines, and pumps.

(b) Reasonable precautions for equipment cleanup shall, at a minimum, include the following:

(i) Storing all wastes and waste materials, including cloth and paper that are contaminated with VOC, in closed containers;

(ii) Preparing written standard operating procedures for frequently cleaned equipment, including when practical, provisions for the use of low-VOC or non-VOC materials and procedures to minimize the quantity of VOC materials used;

(iii) Using enclosed spray gun cleaning, VOC-recycling systems and other spray gun cleaning methods where practical that reduce or eliminate VOC emissions;

and

(iv) Using, when practical, detergents, high-pressure water, or other non-VOC cleaning options to clean coating lines, containers, and process equipment.

(4) VOC Storage and Transfer.

(a) A person subject to this section who stores VOCs shall, at a minimum, install conservation vents or other vapor control measures on storage tanks with a capacity of 2,000 gallons or more to minimize VOC emissions.

(b) A person subject to this section shall, at a minimum, utilize vapor balance, vapor control lines, or other vapor control measures when VOCs are transferred from a tank truck into a stationary storage tank with a capacity greater than 10,000 gallons and less than 40,000 gallons that store VOCs or materials containing VOCs, other than gasoline, that have a vapor pressure greater than 1.5 psia."

COMAR 26.11.19.16C. - General Requirements.

"A person subject to this regulation shall comply with all of the following requirements:

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

- (1) Visually inspect all components on the premises for leaks at least once each calendar month.
- (2) Tag any leak immediately so that the tag is clearly visible. The tag shall be made of a material that will withstand any weather or corrosive conditions to which it may be normally exposed. The tag shall bear an identification number, the date the leak was discovered, and the name of the person who discovered the leak. The tag shall remain in place until the leak has been repaired.
- (3) Take immediate action to repair all observed VOC leaks that can be repaired within 48 hours.
- (4) Repair all other leaking components not later than 15 days after the leak is discovered. If a replacement part is needed, the part shall be ordered within 3 days after discovery of the leak, and the leak shall be repaired within 48 hours after receiving the part.
- (5) Maintain a supply of components or component parts that are recognized by the source to wear or corrode, or that otherwise need to be routinely replaced, such as seals, gaskets, packing, and pipe fittings.
- (6) Maintain a log that includes the name of the person conducting the inspection and the date on which leak inspections are made, the findings of the inspection, and a list of leaks by tag identification number. The log shall be made available to the Department upon request. Leak records shall be maintained for a period of not less than 2 years from the date of their occurrence."

COMAR 26.11.19.06D. Exceptions. "Components that cannot be repaired as required in this regulation because they are inaccessible, or that cannot be repaired during operation of the source, shall be identified in the log and included within the source's maintenance schedule for repair during the next source shutdown."

COMAR 26.11.19.18B. Applicability.

"(1) This regulation applies to a person, owner, or operator who:

- (d) Performs screen printing on untreated sign paper at a premises that causes VOC emissions of 20 pounds or more per day from all printing on untreated sign paper at the premises."

F. General Requirements for Digital Imaging.

"A person who owns or operates digital imaging that is subject to this regulation may not cause the discharge of VOC emissions into the atmosphere in excess of 100 pounds on any day from all digital printing at the premises."

COMAR 26.11.35 – VOC from Adhesives and Sealants

Packaging Adhesive Fugitive Lines S7-16 (MDE Reg. No. 9-1298)

COMAR 26.11.35.01 – Applicability and Exemptions

E. "The provisions of Regulation .04A and D of this chapter do not apply to the use of adhesives, sealants, adhesive primers, sealant primers, cleanup solvents, and surface preparation solvents if:

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

- (1) The total volume of noncomplying adhesives, sealants, primers, cleanup solvents, and surface preparation solvents applied facility-wide does not exceed 55 gallons per calendar year; and
- (2) The person claiming the usage exemption under §E(1) of this regulation maintains monthly operational records sufficient to demonstrate compliance as required by Regulation .05A of this chapter.

Note: In any calendar year in which ASR uses more than 55 gallons of packaging adhesives, ASR must meet the requirements of COMAR 26.11.35.04A and C.

COMAR 26.11.35.04 - Standards.

A." Except as provided in §E of this regulation and Regulation .01 of this chapter, on and after January 1, 2009, a person may not:

- (3) Use or apply an adhesive, sealant, adhesive primer, or sealant primer within the State that exceeds the applicable VOC content limits specified in Table 1."

COMAR 26.11.35.04G - Table 1.

VOC Content Limits for Adhesives, Sealants, Adhesive Primers, Sealant Primers, and Adhesives Applied to Particular Substrates		
Adhesive, sealant, adhesive primer, or sealant primer	VOC content limit	
Category	VOC (grams per liter*)	VOC (pounds per gallon*)
Adhesives Applied to the Listed Substrate		
Porous material	120	1.00

* The VOC content is determined as the weight of volatile compounds, less water and exempt compounds, as specified in Regulation .06 of this chapter.

COMAR 26.11.35.04C. - Surface Preparation or Cleanup Solvent.

- "(1) This section applies to a person subject to this chapter using a surface preparation or cleanup solvent.
- (2) Except as provided in §C(3) of this regulation for single-ply roofing, a person may not use materials for surface preparation containing VOCs unless the VOC content of the surface preparation solvent is less than 70 grams per liter.
- (3) If a surface preparation solvent is used in applying single-ply roofing, a person may not use materials for surface preparation containing VOCs unless the composite vapor pressure, excluding water and exempt compounds, of the surface preparation solvent does not exceed 45 millimeters of mercury at 20°C.
- (4) Except as provided in §C(5) of this regulation, a person may not use materials containing VOCs for the removal of adhesives, sealants, or adhesive or sealant

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

primers from surfaces, other than spray application equipment, unless the composite vapor pressure of the solvent used is less than 45 millimeters of mercury at 20°C.

(5) Removal of an adhesive, sealant, adhesive primer, or sealant primer from the parts of spray application equipment shall be performed as follows:

(a) In an enclosed cleaning system or equivalent cleaning system as determined by the test method identified in Regulation .06H of this chapter;

(b) Using a solvent with a VOC content less than or equal to 70 grams of VOC per liter of material; or

(c) Parts containing dried adhesive may be soaked in a solvent if the composite vapor pressure of the solvent, excluding water and exempt compounds, is less than or equal to 9.5 millimeters of mercury at 20°C and the parts and solvent are in a closed container that remains closed except when adding parts to or removing parts from the container.”

COMAR 26.11.35.04E. “A person using adhesives, sealants, adhesive primers, sealant primers, surface preparation solvents, or cleanup solvents subject to this chapter shall store or dispose of all absorbent materials, such as cloth or paper, that are moistened with adhesives, sealants, primers, or solvents subject to this chapter in nonabsorbent containers that are closed except when placing materials in or removing materials from the container.”

COMAR 26.11.35.04F. “A person may not solicit, require the use, or specify the application of an adhesive, sealant, adhesive primer, sealant primer, surface preparation solvent, or cleanup solvent if the use or application results in a violation of this chapter. This requirement applies to all written or oral contracts under which an adhesive, sealant, adhesive primer, sealant primer, surface preparation solvent, or cleanup solvent subject to this chapter is to be used at a location in the State.”

Compliance Demonstration

Video Inkjet Packaging Lines: S7-15 (MDE Reg. No. 6-2018)

The Permittee shall conduct facility-wide inspections at least once per calendar month to determine the compliance status of facility operations with regard to implementation of “good operating practices” designed to minimize emissions of VOC. [Reference: COMAR 26.11.03.06C]

The Permittee shall:

(1) Visually inspect all components (process equipment, storage tanks, pumps, compressors, valves, flanges, pipeline fittings, pressure relief valves) at the facility for VOC leaks at least once each calendar month;

(2) Tag any VOC leak immediately with I.D. Number, the date VOC leak was discovered, and the name of the person who discovered the VOC leak. The tag is to remain in place until the VOC leak is repaired;

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

- (3) Take immediate action to repair/control all observed VOC leaks that can be repaired within 48 hours;
- (4) Repair all other VOC leaking components not later than 15 days after the VOC leak is discovered in accordance with COMAR 26.11.19.16C(4);
- (5) If a replacement part is needed, it shall be ordered within 3 days after discovery of the VOC leak and the leak shall be repaired within 48 hours after receiving the part;
- (6) Maintain a supply of components or component parts that are recognized by the source to wear or corrode, or that otherwise need to be routinely replaced; and
- (7) Identify in a log, components that cannot be repaired as required by this regulation because they are inaccessible, or that cannot be repaired during operation of the source and include them within the source's maintenance schedule for repair during the next source shutdown.

[Reference: COMAR 26.11.19.16C and D]

Packaging Adhesive Fugitive lines only (MDE Reg. No. 510-0314-9-1298)

(1) The Permittee shall not use any adhesive with a VOC content of greater than 1.0 pound per gallon (120 grams per liter). The VOC content is determined as the weight of volatile compounds, less water and exempt compounds as specified in COMAR 26.11.36.06. **[Reference: COMAR 26.11.35.04G, Table 1, footnote]**

(2) The Permittee shall not use materials for surface preparation containing VOCs unless the VOC content of the surface preparation solvent is less than 70 grams per liter. **[Reference: COMAR 26.11.36.04C(2)]**

(3) The Permittee shall not use materials containing VOCs for the removal of adhesives, sealants, or adhesive or sealant primers from surfaces other than spray application equipment, unless the composite vapor pressure of the solvent used is less than 45 millimeters of mercury at 20°C. Removal of an adhesive sealant, adhesive primer, or sealant primer from the parts of spray application equipment shall be performed according to COMAR 26.11.36.04C(5). **[Reference: COMAR 26.11.36.04C(4) and (5)]**

(4) The Permittee shall store or dispose of all absorbent materials, such as cloth or paper, that are moistened with adhesives, sealants, primers, or solvents subject to COMAR 26.11.36 in nonabsorbent containers that are closed except when placing materials in or removing materials from the container. **[Reference: COMAR 26.11.36.04E]**

Video Inkjet Packaging Lines S7-15 (MDE Reg. No. 6-2018)

The Permittee shall maintain:

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

- (a) Written descriptions of all “good operating practices” designed to minimize emissions of VOC from facility-wide operations. **[Reference: COMAR 26.11.19.02I]**
- (b) Records of all inspections conducted to determine the facility’s compliance status with regard to implementation of “good operating practices” designed to minimize emissions of VOC from facility-wide operations. The records shall include for each inspection the name of the inspector, the date and time of the inspection, and an account of the findings. **[Reference: COMAR 26.11.03.06C]**

The Permittee shall:

- (a) Maintain a log that includes the name of the person conducting the inspection, the date on which VOC leak inspection was made, the findings of the inspection, a list of VOC leaks by tag identification number, the date the part was ordered, and the date the VOC leak was repaired; and
- (b) Make the log available to the Department upon request and shall be maintained for a period of not less than two years from the date of the VOC leaks’ occurrence.
- [Reference: COMAR 26.11.19.16C(6)]**

COMAR 26.11.19.18G - Record Keeping. “A person subject to this regulation shall maintain the following records for not less than 3 years and make the records available to the Department upon request: (3) The VOC content of each ink, coating, cleanup material, or any other material containing VOC that is used at the premises.

Video Inkjet Packaging Lines S7-15 (MDE Reg. No. 6-2018)

Good operating practices information as required by COMAR 26.11.19.02I shall be made available to the Department upon request.

VOC Leak inspection logs as required by COMAR 26.11.19.16 shall be made available to the Department upon request.

Packaging Adhesive Fugitive lines only S7-16 (MDE Reg. No. 510-0314-9-1298)

The Permittee shall report all occurrences of excess emissions to the Department. **[Reference: COMAR 26.11.01.07]**

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Emission Units: D3-6 thru D3-11

Ion Exchange System

- D3-6: Scrubber (25-gpm once through).
- D3-6A: HCl Tank (8450-gallons equipped with scrubber D3-6).
- D3-7: Resin Acid Wash Tank (12,924 gallons).
- D3-8: Clean in Place (CIP) Tank (734 gallons).
- D3-9A, B, C, D: Four (4) Deashing Resin Beds (10, 574 gallons each).
- D3-10A, B, C, D: Four (4) Decolorized Resin Beds (23,603 gallons each).
- D3-11A, B: Two (2) salt saturators controlled by water spray chamber (D3-11).
- D3-12: HCl equipment leak components (valves/pumps/ connectors).
(MDE Reg. No. 510-0314-8-0386).

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. Records of HCl and salt throughput have been maintained onsite and are submitted annually with the Emission Certification Report.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

Compliance Demonstration

The Permittee shall maintain at the facility for at least five (5) years and make them available to the Department upon request records necessary to support annual certifications of emissions. **[Reference: COMAR 26.11.03.06C]**

The Permittee shall submit to the Department by April 1 of each year a certification of emissions for the previous calendar year.

The Permittee shall report all occurrences of excess emissions to the Department. **[Reference: COMAR 26.11.01.07]**

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

B. Control of Particulate Matter

COMAR 26.11.06.03B - Particulate Matter from Confined Sources.

“(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm).”

COMAR 26.11.06.03C - Particulate Matter from Unconfined Sources.

“(1) A person may not cause or permit emissions from an unconfined source without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, when appropriate as determined by the Department, the installation and use of hoods, fans, and dust collectors to enclose, capture, and vent emissions. In making this determination, the Department shall consider technological feasibility, practicality, economic impact, and the environmental consequences of the decision.”

COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction.

“A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:

- (1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.
- (2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.
- (3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.
- (4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.
- (5) The paving of roadways and their maintenance in clean condition.
- (6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water.”

Compliance Demonstration

The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request:

- (a) Annual HCI throughput for each tank and resin bed.
- (b) Annual salt throughput for each salt saturator.

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

(c) All written descriptions of "good operating practices" designed to minimize emissions of HAP.

(d) HAP leak detection and repair logs that include identification of the persons who conducted the leak detection inspections, the dates on which the inspections were conducted, the findings during the inspections, a listing by tag identification number and a description of all leaks discovered, and the date and nature of all leak repairs effected.

[Reference: MDE Permit to Construct No. 510-0314-8-0386 (November 18, 2013)]

The Permittee shall submit to the Department by April 1 of each year a certification of emissions for the previous calendar year.

The Permittee shall report all occurrences of excess emissions to the Department. **[Reference: COMAR 26.11.01.07]**

Emission Units: **S1, S2, S3 & S4**

S1, S2, S3, S4: Four (4) 3.75-million-pound sugar storage silos equipped with bin vents (BV-1, BV-2, BV-3, BV-4) [MDE Reg. No. 510-0314-8-0411]. Permit to Construct issued Feb 25, 2021.

Compliance Status

During the 2022 full compliance report, the refinery was in full operation. As of the EPA six-month reporting period (July 1, 2022, through Dec 31, 2022), the four silos are partially completed as work is still being done on the interior. The Permittee reported via email dated September 5, 2023, that the source is now operational. The operational timelines are as follows: Sugar trial start date: 6/23, Sugar Trial end date: 7/10, First silo in service: 7/10, All four in service: 9/1.

Applicable Standards/Limits

A. Control of Visible Emissions

COMAR 26.11.06.02 - Visible Emission Standards.

C(2) "In Areas III and IV a person may not cause or permit the discharge of emissions from any installation or building, other than water in an uncombined form, which is visible to human observers."

A(2) General Exceptions. "The visible emissions standards in §C of this regulation do not apply to emissions during start-up and process modifications or adjustments, or occasional cleaning of control equipment, if:

- (a) The visible emissions are not greater than 40 percent opacity; and
- (b) The visible emissions do not occur for more than 6 consecutive minutes in any 60-minute period."

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Compliance Demonstration

The Permittee shall perform a walk-through inspection once a month of the facility to look for sources of visible emissions. The Permittee shall visually inspect the exhaust gases from each stack that exhausts outside a building and look at openings in buildings through which visible emissions can escape to the outside. The Permittee shall record the results of each observation.

If visible emissions in the exhaust gases are visible, the Permittee shall perform the following:

- (1) Inspect all process and/or control equipment that may affect visible emissions;
- (2) Perform all necessary repairs and/or adjustments to all processes and/or control equipment, within 48 hours, so that visible emissions in the exhaust gases are eliminated;
- (3) Document, in writing, the results of the inspections and the repairs and/or adjustments made to the processes and/or control equipment; and
- (4) If visible emissions have not eliminated within 48 hours, the Permittee shall perform a Method 9 observation once daily for an 18-minute period until corrective actions have eliminated the visible emissions.

The Permittee shall maintain at the facility for at least five (5) years and make them available to the Department upon request, records of the following:

- (1) A record of the results of the monthly inspections and the log of inspection and maintenance.
- (2) A log with records of the dates and description of maintenance activities performed. [Reference: COMAR 26.11.03.06C]

The Permittee shall report, in accordance with the requirements under COMAR 26.11.01.07, occurrences of excess emissions to the Compliance Program of the Air and Radiation Administration. [Reference: COMAR 26.11.01.07]

B. Control of Particulate Matter

COMAR 26.11.06.03B - Particulate Matter from Confined Sources.

"(2) Areas III and IV. (a) A person may not cause or permit to be discharged into the outdoor atmosphere from any other installation, particulate matter in excess of 0.03 gr/SCFD (68.7 mg/dscm)."

COMAR 26.11.06.03D - Particulate Matter from Materials Handling and Construction.

"A person may not cause or permit any material to be handled, transported, or stored, or a building, its appurtenances, or a road to be used, constructed, altered, repaired, or demolished without taking reasonable precautions to prevent particulate matter from becoming airborne. These reasonable precautions shall include, but not be limited to, the following when appropriate as determined by the control officer:

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

- (1) Use of water or chemicals for control of dust in the demolition of existing buildings or structures, construction operations, the grading of roads, or the clearing of land.
- (2) Application of asphalt, oil, water, or suitable chemicals on dirt roads, materials stockpiles, and other surfaces which can create airborne dusts.
- (3) Installation and use of hoods, fans, and dust collectors to enclose and vent the handling of dusty materials. Adequate containment methods shall be employed during sandblasting of buildings or other similar operations.
- (4) Covering, at all times when in motion, open-bodied vehicles transporting materials likely to create air pollution. Alternate means may be employed to achieve the same results as would covering the vehicles.
- (5) The paving of roadways and their maintenance in clean condition.
- (6) The prompt removal from paved streets of earth or other material which has been transported there by trucks or earth moving equipment or erosion by water."

Compliance Demonstration

The Permittee shall develop and maintain a preventative maintenance plan for each control device that describes the maintenance activity and time schedule for completing each activity. The Permittee shall perform maintenance activities within the time frame established in the plan.

The Permittee shall maintain the following records on site for at least five (5) years and shall be made available to the Department upon request: (1) a copy of the preventative maintenance plan for each of the bin vents; (2) records of the bin vent malfunctions, and corrective actions taken to bring it back into proper operation; and (3) a log with records of the dates and description of maintenance activities performed. [Reference: COMAR 26.11.03.06C]

COMPLIANCE SCHEDULE

American Sugar Refining, Inc. is currently in compliance with all applicable air quality regulations.

TITLE IV – ACID RAIN

Not Applicable.

TITLE VI – OZONE DEPLETING SUBSTANCES

American Sugar Refining, Inc is not subject to Title VI requirements.

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

SECTION 112(r) – ACCIDENTAL RELEASE

American Sugar Refining, Inc is not subject to the requirements of Section 112(r).

PERMIT SHIELD

The American Sugar Refining, Inc facility requested that a permit shield be expressly included in the Permittee's Part 70 permit. Permit shields are granted on an emission unit by emission unit basis. If an emission unit is covered by a permit shield, a permit shield statement will follow the emission unit table in Section IV - Plant Specific Conditions of the permit. In this case, a permit shield was granted for each emission unit covered by the permit.

INSIGNIFICANT ACTIVITIES

This section provides a list of insignificant emissions units that were reported in the Title V permit application. The applicable Clean Air Act requirements, if any, are listed below the insignificant activity.

- (1) No. 1 Stationary internal combustion engines with an output less than 500 brake horsepower (373 kilowatts) and which are not used to generate electricity for sale or for peak or load shaving;

The 250-kW emergency generator is subject to the following requirements:

<p><u>Emissions Unit Number(s): Emergency Generator</u></p> <p>U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.</p>
<p><u>Applicable Standards/Limits:</u></p> <p>A. <u>Control of Visible Emissions</u> COMAR 26.11.09.05E – Stationary Internal Combustion Engine Powered Equipment. “(2) <u>Emissions During Idle Mode.</u> A person may not cause or permit the discharge of emissions from any engine, operating at idle, greater than 10 percent opacity.</p>

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

(3) Emissions During Operating Mode. A person may not cause or permit the discharge of emissions from any engine, operating at other than idle conditions, greater than 40 percent opacity.

(4) Exceptions.

(a) Section E(2) of this regulation does not apply for a period of 2 consecutive minutes after a period of idling of 15 consecutive minutes for the purpose of clearing the exhaust system.

(b) Section E(2) of this regulation does not apply to emissions resulting directly from cold engine start-up and warm-up for the following maximum periods:

(i) Engines that are idled continuously when not in service: 30 minutes;

(ii) All other engines: 15 minutes.

(c) Section E(2) and (3) of this regulation do not apply while maintenance, repair, or testing is being performed by qualified mechanics.”

B. Control of Sulfur Oxides Emission

COMAR 26.11.09.07A(2) – Control of Sulfur Oxides from fuel burning equipment. “A person may not burn, sell, or make available for sale any fuel with a sulfur content by weight in excess of or which otherwise exceeds the following limitations: In Areas III and IV: **(b) Distillate fuel oil, 0.3 percent.**”

C. Control of Nitrogen Oxides Emission

COMAR 26.11.09.08G. - Requirements for Fuel-Burning Equipment with a Capacity Factor of 15 Percent or Less, and Combustion Turbines with a Capacity Factor Greater than 15 Percent.

“(1) A person who owns or operates fuel-burning equipment with a capacity factor (as defined in 40 CFR Part 72.2) of 15 percent or less shall:

(a) Provide certification of the capacity factor of the equipment to the Department in writing;

(b) For fuel-burning equipment that operates more than 500 hours during a calendar year, perform a combustion analysis and optimize combustion at least once annually;

(c) Maintain the results of the combustion analysis at the site for at least 2 years and make these results available to the Department and the EPA upon request;

(d) Require each operator of an installation, except combustion turbines, to attend operator training programs at least once every 3 years, on combustion optimization that are sponsored by the Department, the EPA, or equipment vendors; and

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

(e) Maintain a record of training program attendance for each operator at the site and make these records available to the Department upon request.”

D. Control of HAPs

Subpart III—Standards of Performance for Stationary Compression Ignition Internal Combustion Engines

§60.4200 - Am I subject to this subpart?

(a) The provisions of this subpart are applicable to manufacturers, owners, and operators of stationary compression ignition (CI) internal combustion engines (ICE) and other persons as specified in paragraphs (a)(1) through (4) of this section. For the purposes of this subpart, the date that construction commences is the date the engine is ordered by the owner or operator.

(1) Manufacturers of stationary CI ICE with a displacement of less than 30 liters per cylinder where the model year is: 2007 or later, for engines that are not fire pump engines.

§60.4205 - What emission standards must I meet for emergency engines if I am an owner or operator of a stationary CI internal combustion engine?

(b) Owners and operators of 2007 model year and later emergency stationary CI ICE with a displacement of less than 30 liters per cylinder that are not fire pump engines must comply with the emission standards for new nonroad CI engines in § 60.4202, for all pollutants, for the same model year and maximum engine power for their 2007 model year and later emergency stationary CI ICE.

Note: The Permittee shall satisfy the requirements above and §60.4202 by purchasing and installing engines certified at EPA Tier 2 or better.

§60.4207 - What fuel requirements must I meet if I am an owner or operator of a stationary CI internal combustion engine subject to this subpart?

(b) Beginning October 1, 2010, owners and operators of stationary CI ICE subject to this subpart with a displacement of less than 30 liters per cylinder that use diesel fuel must use diesel fuel that meets the requirements of 40 CFR 80.510(b) for nonroad diesel fuel, except that any existing diesel fuel purchased (or otherwise obtained) prior to October 1, 2010, may be used until depleted.

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

§60.4209 - What are the monitoring requirements if I am an owner or operator of a stationary CI internal combustion engine?

If you are an owner or operator, you must meet the monitoring requirements of this section. In addition, you must also meet the monitoring requirements specified in § 60.4211.

(a) If you are an owner or operator of an emergency stationary CI internal combustion engine that does not meet the standards applicable to non-emergency engines, you must install a non-resettable hour meter prior to startup of the engine.

(b) If you are an owner or operator of a stationary CI internal combustion engine equipped with a diesel particulate filter to comply with the emission standards in § 60.4204, the diesel particulate filter must be installed with a backpressure monitor that notifies the owner or operator when the high backpressure limit of the engine is approached.

§60.4211 - What are my compliance requirements if I am an owner or operator of a stationary CI internal combustion engine?

(a) If you are an owner or operator and must comply with the emission standards specified in this subpart, you must do all of the following, except as permitted under paragraph (g) of this section:

- (1) Operate and maintain the stationary CI internal combustion engine and control device according to the manufacturer's emission-related written instructions;
- (2) Change only those emission-related settings that are permitted by the manufacturer; and
- (3) Meet the requirements of 40 CFR part 1068, as they apply to you.

(c) If you are an owner or operator of a 2007 model year and later stationary CI internal combustion engine and must comply with the emission standards specified in §60.4204(b) or §60.4205(b), or if you are an owner or operator of a CI fire pump engine that is manufactured during or after the model year that applies to your fire pump engine power rating in table 3 to this subpart and must comply with the emission standards specified in §60.4205(c), you must comply by purchasing an engine certified to the emission standards in §60.4204(b), or §60.4205(b) or (c), as applicable, for the same model year and maximum (or in the case of fire pumps, NFPA nameplate) engine power.

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

The engine must be installed and configured according to the manufacturer's emission-related specifications, except as permitted in paragraph (g) of this section.

(f) If you own or operate an emergency stationary ICE, you must operate the emergency stationary ICE according to the requirements in paragraphs (f)(1) through (3) of this section. In order for the engine to be considered an emergency stationary ICE under this subpart, any operation other than emergency operation, maintenance and testing, and operation in nonemergency situations for 50 hours per year, as described in paragraphs (f)(1) through (3), is prohibited. If you do not operate the engine according to the requirements in paragraphs (f)(1) through (3), the engine will not be considered an emergency engine under this subpart and must meet all requirements for non-emergency engines.

- (1) There is no time limit on the use of emergency stationary ICE in emergency situations.
- (2) You may operate your emergency stationary ICE for any combination of the purposes specified in paragraphs (f)(2)(i) of this section for a maximum of 100 hours per calendar year. Any operation for non-emergency situations as allowed by paragraph (f)(3) of this section counts as part of the 100 hours per calendar year allowed by this paragraph (f)(2).
 - (i) Emergency stationary ICE may be operated for maintenance checks and readiness testing, provided that the tests are recommended by federal, state or local government, the manufacturer, the vendor, the regional transmission organization or equivalent balancing authority and transmission operator, or the insurance company associated with the engine. The owner or operator may petition the Administrator for approval of additional hours to be used for maintenance checks and readiness testing, but a petition is not required if the owner or operator maintains records indicating that federal, state, or local standards require maintenance and testing of emergency ICE beyond 100 hours per calendar year.
 - (ii) –(iii) [Reserved]

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

(3) Emergency stationary ICE may be operated for up to 50 hours per calendar year in non-emergency situations. The 50 hours of operation in non-emergency situations are counted as part of the 100 hours per calendar year for maintenance and testing and emergency demand response provided in paragraph (f)(2) of this section. Except as provided in paragraph (f)(3)(i) of this section, the 50 hours per calendar year for non-emergency situations cannot be used for peak shaving or non-emergency demand response, or to generate income for a facility to an electric grid or otherwise supply power as part of a financial arrangement with another entity.

(i) The 50 hours per year for non-emergency situations can be used to supply power as part of a financial arrangement with another entity if all of the following conditions are met:

(A) The engine is dispatched by the local balancing authority or local transmission and distribution system operator;

(B) The dispatch is intended to mitigate local transmission and/or distribution limitations so as to avert potential voltage collapse or line overloads that could lead to the interruption of power supply in a local area or region.

(C) The dispatch follows reliability, emergency operation or similar protocols that follow specific NERC, regional, state, public utility commission or local standards or guidelines.

(D) The power is provided only to the facility itself or to support the local transmission and distribution system.

(E) The owner or operator identifies and records the entity that dispatches the engine and the specific NERC, regional, state, public utility commission or local standards or guidelines that are being followed for dispatching the engine. The local balancing authority or local transmission and distribution system operator may keep these records on behalf of the engine owner or operator.

(ii) [Reserved]

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

Emissions Unit Number(s): Emergency Generator

U11-2: 250-kW Emergency Generator. [MDE Reg. 9-1293]. Installed 2020.

§60.4214 - What are my notification, reporting, and recordkeeping requirements if I am an owner or operator of a stationary CI internal combustion engine?

(d) If you own or operate an emergency stationary CI ICE with a maximum engine power more than 100 HP that operates for the purpose specified in § 60.4211(f)(3)(i), you must submit an annual report according to the requirements in paragraphs (d)(1) through (3) of this section.

(1) The report must contain the following information:

(i) Company name and address where the engine is located.

(ii) Date of the report and beginning and ending dates of the reporting period.

(iii) Engine site rating and model year.

(iv) Latitude and longitude of the engine in decimal degrees reported to the fifth decimal place.

(v)-(vi) [Reserved]

(vii) Hours spent for operation for the purposes specified in § 60.4211(f)(3)(i), including the date, start time, and end time for engine operation for the purposes specified in § 60.4211(f)(3)(i). The report must also identify the entity that dispatched the engine and the situation that necessitated the dispatch of the engine.

40 CFR 63 Subpart ZZZZ—National Emissions Standards for Hazardous Air Pollutants for Stationary Reciprocating Internal Combustion Engines.

§63.6590 - What parts of my plant does this subpart cover?

"(c) Stationary RICE subject to Regulations under 40 CFR Part 60. An affected source that meets any of the criteria in paragraphs (c)(1) through (7) of this section must meet the requirements of this part by meeting the requirements of 40 CFR part 60 subpart IIII, for compression ignition engines or 40 CFR part 60 subpart JJJJ, for spark ignition engines. No further requirements apply for such engines under this part.

(1) A new or reconstructed stationary RICE located at an area source;"

- (2) Space heaters utilizing direct heat transfer and used solely for comfort heat;
- (3) No. 5 Unheated VOC dispensing containers or unheated VOC rinsing containers of 60 gallons (227 liters) capacity or less;

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

The affected units are subject to COMAR 26.11.19.09D, which requires that the Permittee control emissions of volatile organic compounds (VOC) from cold degreasing operations by meeting the following requirements:

- (a) COMAR 26.11.19.09D(2)(b), which establishes that the Permittee shall not use any VOC degreasing material that exceeds a vapor pressure of 1 mm Hg at 20 ° C;
- (b) COMAR 26.11.19.09D(3)(a—d), which requires that the Permittee implement good operating practices designed to minimize spills and evaporation of VOC degreasing material. These practices, which shall be established in writing and displayed such that they are clearly visible to operators, shall include covers (including water covers), lids, or other methods of minimizing evaporative losses, and reducing the time and frequency during which parts are cleaned;
- (c) COMAR 26.11.19.09D(4), which prohibits the use of any halogenated VOC for cold degreasing.

The Permittee shall maintain on site for at least five (5) years, and shall make available to the Department upon request, the following records of operating data:

- (a) Monthly records of the total VOC degreasing materials used; and
 - (b) Written descriptions of good operating practices designed to minimize spills and evaporation of VOC degreasing materials.
- (4) Containers, reservoirs, or tanks used exclusively for:
- (a) Storage of butane, propane, or liquefied petroleum, or natural gas;
 - (b) No. 4 Storage of lubricating oils;
 - (c) No. 2 Storage of Numbers 1, 2, 4, 5, and 6 fuel oil and aviation jet engine fuel;

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

- (d) No. 1 The storage of VOC normally used as solvents, diluents, thinners, inks, colorants, paints, lacquers, enamels, varnishes, liquid resins, or other surface coatings and having individual capacities of 2,000 gallons (7.6 cubic meters) or less;
- (5) Charbroilers and pit barbecues as defined in COMAR 26.11.18.01 with a total cooking area of 5 square feet (0.46 square meter) or less;
- (6) First aid and emergency medical care provided at the facility, including related activities such as sterilization and medicine preparation used in support of a manufacturing or production process;
- (7) Comfort air conditioning subject to requirements of Title VI of the Clean Air Act;
- (8) Laboratory fume hoods and vents;

For the following, attach additional pages as necessary:

- (9) any other emissions unit, not listed in this section, with a potential to emit less than the "de minimus" levels listed in COMAR 26.11.02.10X (list and describe units):

No. 2 Aerosol can puncture equipment. _____

No. 1 Maintenance welding (U11-3) _____

No. 1 Maintenance steel cutting (U11-4) _____

STATE ONLY ENFORCEABLE REQUIREMENTS

This section of the permit contains state-only enforceable requirements. The requirements in this section will not be enforced by the U.S. Environmental

AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET

Protection Agency. The requirements in this section are not subject to COMAR 26.11.03 10 - Public Petitions for Review to EPA Regarding Part 70 Permits.

1. Applicable Regulations:

(A) **COMAR 26.11.06.08 - Nuisance.**

"An installation or premises may not be operated or maintained in such a manner that a nuisance or air pollution is created. Nothing in this regulation relating to the control of emissions may in any manner be construed as authorizing or permitting the creation of, or maintenance of, nuisance or air pollution."

(B) **COMAR 26.11.06.09 - Odors.**

"A person may not cause or permit the discharge into the atmosphere of gases, vapors, or odors beyond the property line in such a manner that a nuisance or air pollution is created."

(C) **COMAR 26.11.15.05, Control Technology Requirements.**

"A person who complies with the ambient impact requirement in Regulation .06 of this chapter may not be affected by the amount of the installation's stack height that exceeds good engineering practice (GEP), or by any other dispersion technique.

Unless an existing installation is controlled using T-BACT, the degree of emission limitation required in order to demonstrate compliance with Regulation .06 of this chapter may not be affected by the amount of the installation's stack height that exceeds good engineering practice (GEP), or by any other dispersion technique."

(D) **COMAR 26.11.15.06, Ambient Impact Requirement – Requirements for Existing Installations, Sources, or Premises.**

1) "Except as provided in §B(3) of this regulation, a person may not cause or permit the discharge of a toxic air pollutant listed in COMAR 26.11.16.07 from an existing installation or source if total allowable emissions of that TAP from the premises will unreasonably endanger human health.

2) A person shall demonstrate compliance with §B(1) of this regulation using the procedures established in Regulation .07 of this chapter and COMAR 26.11.16.

3) A person who owns or operates an existing premises shall meet the requirements of §B(1) and (2) of this regulation for each TAP listed in COMAR 26.11.16.07 by the applicable compliance dates listed in COMAR 26.11.16.07, or not later than 2 years after becoming subject to this chapter, whichever is later."

2. Record Keeping and Reporting:

**AMERICAN SUGAR REFINING, INC.
1100 KEY HIGHWAY EAST
BALTIMORE, MD 21230
PERMIT NO. 24-510-0314
PART 70 OPERATING PERMIT FACT SHEET**

The Permittee shall submit to the Department, by April 1 of each year during the term of this permit, a written certification of the results of an analysis of emissions of toxic air pollutants from the Permittee's facility during the previous calendar year. The analysis shall include either:

- (a) a statement that previously submitted compliance demonstrations for emissions of toxic air pollutants remain valid; or
- (b) a revised compliance demonstration, developed in accordance with requirements included under COMAR 26.11.15 & 16, that accounts for changes in operations, analytical methods, emissions determinations, or other factors that have invalidated previous demonstrations.