FLORIDA DEPARTMENT OF ENVIRONMENTAL PROTECTION

NORTHEAST DISTRICT
8800 BAYMEADOWS WAY WEST, SUITE 100
JACKSONVILLE, FLORIDA 32256

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GOVERNOR

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SECRETARY

Permittee:
Kraft Foods Group, Inc., Maxwell House Coffee
735 East Bay Street
Jacksonville, FL 32202

Permit No.: 0310004-021-AC
Facility ID No.: 0310004
SIC No(s): 20
Project: Gevalia Bean Processing System Modifications

This is the final air construction permit which authorizes the modification of the Gevalia Roasted Bean Processing System, including the addition of Emission Unit No. 560 for the installation of two new destoners and a Farr Gold Series Dust Collector for the handling of roasted Gevalia/Tassimo beans, the removal of EU No. 515 as a permitted EU upon construction and operational testing of the new cable conveyance system for transport of the roasted Gevalia/Tassimo beans to the weighing scale, and the shutdown of EU No. 514, Thermalo Stoners, upon completion and testing of the new Emission Unit No. 560. This work will occur at the Kraft Foods Group, Inc., Maxwell House Coffee facility which produces roasted coffee with batch roasters. This facility is located at 735 East Bay Street, Jacksonville, Duval County, FL; UTM Coordinates: Zone 17, 437.54 km East and 3354.71 km North; Latitude: 30° 19’ 27” North and Longitude: 81° 38’ 53” West. As noted in the Final Determination provided with this final permit, only minor changes and clarifications were made to the draft permit.

This final permit is organized by the following sections.

Section 1. General Information

Section 2. Administrative Requirements

Section 3. Emissions Unit Specific Conditions

Section 4. Appendices

Because of the technical nature of the project, the permit contains numerous acronyms and abbreviations, which are defined in Appendix A of Section 4 of this permit.

This air pollution construction permit is issued under the provisions of: Chapter 403 of the Florida Statutes (F.S.) and Chapters 62-4, 62-204, 62-210, 62-212, 62-296 and 62-297 of the Florida Administrative Code (F.A.C.). The permittee is authorized to conduct the proposed work in accordance with the conditions of this permit. This project is subject to the general preconstruction review requirements in Rule 62-212.300, F.A.C. and is not subject to the preconstruction review requirements for major stationary sources in Rule 62-212.400, F.A.C. for the Prevention of Significant Deterioration (PSD) of Air Quality.

Upon issuance of this final permit, any party to this order has the right to seek judicial review of it under Section 120.68 of the Florida Statutes by filing a notice of appeal under Rule 9.110 of the Florida Rules of Appellate Procedure with the clerk of the Department of Environmental Protection in the Office of General Counsel (Mail Station #35, 3900 Commonwealth Boulevard, Tallahassee, Florida, 32399-3000) and by filing a copy of the notice of appeal accompanied by the applicable filing fees with the appropriate District Court of Appeal. The notice must be filed within 30 days after this order is filed with the clerk of the Department.

Executed in Jacksonville, Florida

Richard S. Rachal III, P.G.
Program Administrator
Waste and Air Resource Management Program

CERTIFICATE OF SERVICE

The undersigned duly designated deputy agency clerk hereby certifies that this Final Air Permit package (including the Final Determination and Final Permit) was sent by electronic mail (or a link to these documents made available electronically on a publicly accessible server) with received receipt requested before the close of business on September 4, 2013 to the persons listed below.

Jay Waryold, Kraft Foods Group, Inc.: jwaryold@kraftfoods.com
Lynsey Ellis, Kraft Foods Group, Inc.: lnellis@kraft.com
Stephen Alexander, P.E., Whitmer Environmental Services, Inc.: steveair57@yahoo.com
George Whitmer, Whitmer Environmental Services, Inc.: george@whitmerenv.com

Clerk Stamp

FILING AND ACKNOWLEDGMENT FILED, on this date, pursuant to Section 120.52(7), Florida Statutes, with the designated agency clerk, receipt of which is hereby acknowledged.

_____ September 4, 2013
(Clerk) (Date)

Facility/Project Description

Kraft Foods Group, Inc., Maxwell House Coffee produces roasted coffee with batch roasters. The facility consists essentially of material handling, cleaning, roasting, cooling, grinding, and packaging operations.

Proposed Project

The purpose of this permit is to authorize the modification of the Gevalia Roasted Bean Processing System, including the addition of Emission Unit No. 560 for the installation of two new destoners and a Farr Gold Series Dust Collector for the handling of roasted Gevalia/Tassimo beans, the removal of EU No. 515 as a permitted EU upon construction and operational testing of the new cable conveyance system for transport of the roasted Gevalia/Tassimo beans to the weighing scale, and the shutdown of EU No. 514, Thermalo Stoners, upon completion and testing of the new Emission Unit No. 560. The following emissions units will be modified/created:

Facility ID No. 0310004

ID No.	Emission Unit Description
515	Thermalo Scale
514	Thermalo Destoners
560	New Thermalo Destoners

EU-515: Thermalo Scale: Presently whole roasted beans are pneumatically conveyed to the Thermalo scale for product weighing. Particulate emissions from this process exit through a cyclone. Because Gevalia and Tassimo beans are more delicate, pneumatic conveyances will be replaced with cable conveyances which do not require a cyclone. Therefore, the existing cyclone will be eliminated and EU-515 will be eliminated as an emissions unit.

EU-514: Thermalo Destoners: New destoners will replace the existing destoners and the MAC baghouse. The planned shutdown of this process is September and the EU will be deleted from the permit.

New EU-560: Gevalia/Tassimo Destoners: New destoners will replace the existing ones in the existing EU-514. The emissions from these new destoners will be directed to a new Farr Gold Series Dust Collector.

FACILITY REGULATORY CLASSIFICATION

- The facility is a major source of air pollution because the potential emissions of at least one regulated air pollutant is greater than 100 tons per year pursuant to Chapter 62-210, F.A.C., and Rule 2.301, Jacksonville Environmental Protection Board (JEPB).
- The facility has no units subject to the acid rain provisions of the Clean Air Act (CAA).
- The facility is a Title V major source of air pollution in accordance with Chapter 213, F.A.C. and Rule 2.501, JEPB.
- The facility is not a major stationary source in accordance with Rule 62-212.400(PSD), F.A.C. and Rule 2.401, JEPB
- The facility is not a major source of hazardous air pollutants (HAP).

1. Permitting Authority & Compliance Authority: The permitting authority for this project is the Florida Department of Environmental Protection (Department), Northeast District Office, Waste and Air Resource Management, 8800 Baymeadows Way West, Suite 100, Jacksonville, FL 32256. All documents related to applications for permits to operate an emissions unit shall be submitted to the Northeast District Office, Waste and Air Resource Management Program.

   The compliance authority for this project is the Florida Department of Environmental Protection (Department), Northeast District Office, Compliance Assurance, 8800 Baymeadows Way West, Suite 100, Jacksonville, FL 32256. All documents related to compliance for an emissions unit shall be submitted to the Northeast District Office, Compliance Assurance.

   The Permitting Authority and Compliance Authority phone number is 904-256-1700.

2. Appendices: The following Appendices are attached as part of this permit:

   a. Appendix A. Citation Formats and Glossary of Common Terms;

   b. Appendix B. General Conditions;

   c. Appendix C. Common Conditions; and

   d. Appendix D. Common Testing Requirements.

3. Applicable Regulations, Forms and Application Procedures: Unless otherwise specified in this permit, the construction and operation of the subject emissions units shall be in accordance with the capacities and specifications stated in the application. The facility is subject to all applicable provisions of: Chapter 403, F.S.; and Chapters 62-4, 62-204, 62-210, 62-212, 62-213, 62-296 and 62-297, F.A.C. Issuance of this permit does not relieve the permittee from compliance with any applicable federal, state, or local permitting or regulations.

4. New or Additional Conditions: For good cause shown and after notice and an administrative hearing, if requested, the Department may require the permittee to conform to new or additional conditions. The Department shall allow the permittee a reasonable time to conform to the new or additional conditions, and on application of the permittee, the Department may grant additional time. [Rule 62-4.080, F.A.C.]

5. Modifications: The permittee shall notify the Compliance Authority upon commencement of construction. No new emissions unit shall be constructed and no existing emissions unit shall be modified without obtaining an air construction permit from the Department. Such permit shall be obtained prior to beginning construction or modification. [Rules 62-210.300(1) and 62-212.300(1)(a), F.A.C.]

6. Source Obligation:

   (a) At such time that a particular source or modification becomes a major stationary source or major modification (as these terms were defined at the time the source obtained the enforceable limitation) solely by virtue of a relaxation in any enforceable limitation which was established after August 7, 1980, on the capacity of the source or modification otherwise to emit a pollutant, such as a restriction on hours of operation, then the requirements of subsections 62-212.400(4) through (12), F.A.C., shall apply to the source or modification as though construction had not yet commenced on the source or modification.

(b) At such time that a particular source or modification becomes a major stationary source or major modification (as these terms were defined at the time the source obtained the enforceable limitation) solely by exceeding its projected actual emissions, then the requirements of subsections 62-212.400(4) through (12), F.A.C., shall apply to the source or modification as though construction had not yet commenced on the source or modification. [Rule 62-212.400(12), F.A.C.]

7. Application for Title V Permit: This permit authorizes construction of the permitted emissions unit(s) and initial operation to determine compliance with Department rules. A Title V air operation permit is required for regular operation of the permitted emissions unit. The permittee shall apply for a Title V air operation permit at least 90 days prior to expiration of this permit, but no later than 180 days after commencing operation. To apply for a Title V operation permit, the applicant shall submit the appropriate application form, compliance test results, and such additional information as the Department may by law require. The application shall be submitted to the appropriate Permitting Authority with copies to the Compliance Authority.

   [Rules 62-4.030, 62-4.050, 62-4.220 and Chapter 62-213, F.A.C.]

Subsection A. Emission Unit No. 560

This section of the permit addresses the following emissions units.

ID No.	Emission Unit Description
560	Gevalia/Tassimo Destoners -- Two (2) new destoners will replace the existing destoners to remove stones and other waste that were not removed in the initial cleaning process, from the roasted Gevalia and/or Tassimo beans. Particulate matter (PM) from both of the destoners will be controlled with a single Farr Gold Series Dust Collector.

This emissions unit is subject to the requirements of Rule 62-296.700, F.A.C., and Rule 2.1101, JEPB, Reasonably Available Control Technology (RACT) Particulate Matter; and Rule 62-296.711, F.A.C. and Rule 2.1101, JEPB, Materials Handling, Sizing, Screening, Crushing and Grinding Operations.

Essential Potential to Emit (PTE) Parameters

1. The maximum process rate for each destoner shall not exceed 4,000 pounds per hour of coffee beans.

   [Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

2. The nominal volumetric flow rate for the baghouse is 8,000 cubic feet per minute.

   [Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

3. This emissions unit is allowed to operate continuously, i.e., 8,760 hours per year.

   [Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

Emission Limitations and Standards

4. PM emissions (from baghouse) shall not exceed 0.03 grains per dry standard cubic foot, equivalent emissions 2.06 pounds per hour and 9.01 tons per year.

   [Rule 62-296.711(2), F.A.C., and Rule 2.1101, JEPB]

5. VE (from baghouse) shall not exceed 5 percent opacity.

   [Rules 62-296.711(2) and 62-297.620(4), F.A.C., and Rules 2.1101 and 2.1201, JEPB]

Test Methods and Procedures

6. Testing for demonstration of compliance shall be performed, upon request of the Department, in accordance with EPA RM 5 (as described in 40 CFR 60, Appendix A) for particulate matter. The minimum sample volume shall be 30 dry standard cubic feet.

   [Rules 62-296.711(3), 62-297.620(4), and 62-204.800(8)(e)3. F.A.C.; and Rules 2.1101, 2.1201, and 2.201 JEPB]

7. Testing for demonstration of compliance shall be performed in accordance with EPA RM 9 (as described in 40 CFR 60, Appendix A) for the visual determination of opacity.

   [Rules 62-297.310(4)(a)2. and 62-204.800(8)(e)4., F.A.C., and Rules 2.1201 and 2.201, JEPB]

8. Initial VE testing shall be conducted within 180 days after start-up of the new system and the testing results submitted to the Department with the Title V Air Operation permit revision application or within 45 days of completion of testing, whichever occurs first.

   [Rules 62-4.070(3), 62-297.310(8)(b), F.A.C.; and Rules 2.1401 and 2.1101, JEPB]

Reporting Requirements

9. The permittee shall submit the Operation and Maintenance Plan, including baghouse model no., manufacturer's specifications, and other descriptive and operational information required (see Rule 62-296.700(6), F.A.C. and Rule 2.1101, JEPB), with the Title V Air Operation permit revision application.

   [Rule 62-296.700(6), F.A.C.; and Rule 2.1101, JEPB]

Subsection B. Emission Unit No. 515

Emissions Unit No. 515 – Thermalo Scale

Emissions Unit Description - Roasted beans are pneumatically conveyed to the Thermalo scale for product weighing.

Control Device - Cyclone

As part of the production process change for the Gevalia or Tassimo beans the pneumatic conveying system for the conveyance of standard roasted beans from the Thermalo roasters to the Thermalo scales shall be replaced by a cable conveyance system for the Gevalia or Tassimo beans because of the delicate, fragile nature of this type of roasted bean. Cyclones are not required for this new, cable conveyance operation. Upon completion of construction and operational testing of the new cable conveyance system for the Gevalia/Tassimo roasted beans the permittee shall notify the Department of the official shutdown date of Emission Unit No. 515 as a source of air pollution.

Subsection C. Emission Unit No. 514

Emissions Unit No. 514 – Thermalo Destoners

Emissions Unit Description - Two (2) destoners are used to remove stones and other waste from the roasted beans that were not removed in the initial cleaning process. The function of this EU shall be replaced by EU No. 560.

Control Device - (2) cyclones in series with a MAC Model 96AVR80 Style III Baghouse

Essential Potential to Emit (PTE) Parameters

1. The maximum process rate for each destoner shall not exceed 3,100 pounds per hour of coffee beans.

   [Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

2. The nominal volumetric flow rate is 7,000 cubic feet per minute.

   [Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

3. This emissions unit is allowed to operate continuously, i.e., 8,760 hours per year.

   [Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

Emission Limitations and Standards

4. PM emissions shall not exceed to 0.011 grain per dry standard cubic foot, 0.68 pound per hour, and 3.00 tons per year.

   [Applicant's Request, Rule 62-296.711(2), F.A.C., and Rule 2.1101, JEPB]

5. VE shall not exceed 5 percent opacity.

   [Rule 62-296.711(2), F.A.C., and Rule 2.1101, JEPB]

Test Methods and Procedures

6. Testing for demonstration of compliance shall be performed in accordance with EPA RM 5 (as described in 40 CFR 60, Appendix A) for particulate matter.

   [Rule 62-297.310(4), F.A.C., and Rule 2.1201, JEPB]

7. Testing for demonstration of compliance shall be performed in accordance with EPA RM 9 (as described in 40 CFR 60, Appendix A) for the visual determination of opacity.

   [Rule 62-297.310(4)(a)2., F.A.C., and Rule 2.1201, JEPB]

8. PM and VE shall be tested annually from the date of May 1, 2012.

   [Rule 62-4.070(3), F.A.C., and Rule 2.1401, JEPB]

Reporting Requirements

9. The permittee shall submit the final shutdown date of this emission unit to the Department no later than 30 days after occurrence.

   [Rule 62-4.070(3), F.A.C. and Rule 2.1401, JEPB]