FLORIDA DEPARTMENT OF ENVIRONMENTAL PROTECTION

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

RICK SCOTT
GOVERNOR

HERSCHEL T. VINYARD JR.
SECRETARY

Sent by Electronic Mail – Received Receipt Requested

PERMITTEE

Kraft Foods Group Inc.
735 E. Bay Street
Jacksonville, Florida 32202

Authorized Representative:
Joe Waryold, Plant Manager

Air Permit No. 0310004-023-AC
Permit Expires: October 15, 2014

Kraft Foods Maxwell House Coffee
Air Construction Permit
Hammer Mill Baghouse

This is the final air construction permit, which authorizes the installation of a baghouse to the hammer mills (EU 561) at the facility for particulate matter emissions control. The proposed work will be conducted at Kraft Foods Group, Inc., Maxwell House Coffee facility which produces roasted coffee with batch roasters (Standard Industrial Classification No. 2085). 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.

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 October 15,2013 to the persons listed below.

Joe Waryold, Plant Manager, Kraft Foods, Inc,.jwaryold@kraftfoods.com
George Whitmer, Consultant, Whitmer Environmental Services, Inc george@whitmerenv.com
Stephen Alexander P.E. Whitmer Environmental Services, Inc steveair57@yahoo.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.

(Clerk) October 15, 2013 (Date)

FACILITY AND 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.
There are 10 grinders that grind roasted whole beans into roasted coffee. Ground coffee from the grinders goes through a sifter that separates the larger particles of coffee. The sifted products goes to the filling line, the retained larger particles that did not meet the desired size go to the hammer mill for further grinding. Once ground to desired size the coffee particles return to the sifter and the filling line.

Proposed Project

Installation of a baghouse to the hammer mills (EU 561) for particulate matter emissions control.

This project authorizes the installation of the following emissions unit.

Facility ID No. 0310004	
ID No.	**Emission Unit Description**
561	Hammer Mills Farr Dust Collector Model GS2

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 is not a major source of hazardous air pollutants (HAP).
- 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 a not major stationary source in accordance with Rule 62-212.400(PSD), F.A.C. and Rule 2.401, JEPB
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SECTION 2. ADMINISTRATIVE REQUIREMENTS (FINAL)

1. Permitting Authority: The permitting authority for this project is the Northeast District Office, Waste and Air Resource Management, Florida Department of Environmental Protection (Department). The Northeast District Office's mailing address is 8800 Baymeadows Way West, Suite 100, Jacksonville, Florida 32256. All documents related to applications for permits to operate an emissions unit shall be submitted to the Northeast District Office. The Permitting Authority's telephone number is (904) 256-1700.

2. Compliance Authority: 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.

3. 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.

4. 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.

5. 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.]

6. 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.]

7. 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.]

8. Application for Title V Permit: This permit authorizes construction of the permitted emissions unit 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.]

This section of the permit addresses the following emissions unit.

ID No.	Emission Unit Description
561	Hammer Mills Farr Dust Collector, Gold Series Model GS2 (1300 cfm)

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. **Operating Capacity**: The maximum throughput rate of hammer mill shall not exceed 60,000 pounds per hour of ground coffee

   [Rule 62-210.200 (PTE), FAC, and Rule 2.301, JEPB]

2. **Control Unit:** The emissions from the hammer mills shall be controlled by the permitted baghouse (1300 acfm Gold Series Model GS2). The baghouse shall be in operation at all times during operation of the hammer mills. If there is a malfunction on the control unit, the owner or operator shall shut the baghouse fan immediately to minimize excess emissions.

   [Rule 62-210.700(1) and 62-21.650, F.A.C]

3. **Hours of Operation:** The hours of operation are not limited (8760 hours per year).

   [Rules 62-4.070(3) and 62-210.200(PTE), F.A.C.]

Emission Limitations and Standards

4. **Particulate Matter Emissions:** PM emissions (from baghouse) vent or stack shall not exceed 0.03 grains per dry standard cubic foot, equivalent emissions 0.334 pounds per hour and 1.464 tons per year.

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

5. **Visible Emissions:** Visible emissions (from baghouse) shall not exceed 5 percent opacity.

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

Test Methods and Procedures

6. **Initial Compliance Test:** Compliance shall be determined by a visible emissions test indicating no visible emissions (5 percent opacity) from the baghouse in lieu of a P.M. stack test.

   Testing for demonstration of compliance for P.M. 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 62-297.620, 62-296.711(3)(c),F.A.C. ,62-204.800(8)(e)3. F.A.C.; and Rules 2.1101, 2.1201, and 2.201 JEPB]

7. **Test Method (VE):** The test method for visible emissions shall be shall be EPA Method 9, incorporated and adopted by reference in Chapter 62-297, F.A.C. The test shall be conducted by an observer certified in accordance with the requirements of Rule 62-297.320, F.A.C. – Standards for Persons Engaged in Visible Emissions Observations (specified in Subsection D). The above method is described in Appendix A of 40 CFR 60 and are adopted by reference in Rule 62-204.800, F.A.C.

   [Rules 62-296.711(3)(a), 62-297.620(4),and 62-204.800(8)(e)3. F.A.C.; Appendix A of 40 CFR 60and Rules 2.1101, 2.1201, and 2.201 JEPB]

8. **Initial Compliance Test**: Initial compliance test 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]

RECORDS AND REPORTS

9. This Facility is subject to SECTION 2. Administrative Requirements of this permit and also, the attached Appendices.

10. 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]