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

FINAL Permit No.: 0310004-013-AC
Facility ID No.: 0310004
SIC Nos.: 20
Project: Coffee Bean Handling and Storage

This permit is for the construction of Roasted Whole Bean Handling and Green Bean Storage with the elimination of Emissions Unit 507 - Green Bean Separators and Emissions Unit 508 - Green Bean Scalpers. This facility is located at 735 East Bay Street, Jacksonville, Duval County, FL; UTM Coordinates: Zone 17, 437.5 km East and 3354.7 km North; Latitude: 30° 19' 27" North and Longitude: 81° 39' 00" West.

This permit is issued under the provisions of Chapter 403, Florida Statutes (FS) and Florida Administrative Code (FAC) Chapters 62-4, 62-204, 62-210, 62-212, 62-213, 62-296, and 62-297. The above named permittee is hereby authorized to perform the work or operate the facility shown on the application and approved drawing(s), plans, and other documents, attached hereto or on file with the Environmental Resource Management Department, Environmental Quality Division (Department) in accordance with the terms and conditions of this permit.

Title V Operation Permit Revision Application Due Date: October 1, 2006

Expiration Date: March 31, 2007

Environmental Resource Management Department
Environmental Quality Division

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Robert Steven Pace, P.E., Manager
Air Quality Branch

RSP/RR/rdr

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Section I. Facility Information

Subsection A. Facility/Project Description

This permit is for the construction of Roasted Whole Bean Handling and Green Bean Storage and the elimination of Emissions Unit (EU) 507 - Green Bean Separators and EU 508 - Green Bean Scalpers. Equipment used for EU 507 will be reconfigured to operate as Roasted Whole Bean Handling. Equipment used for EU 508 will be reconfigured to operate as Green Bean Storage.

Prevention of Significant Deterioration requirements do not apply since this modification does not constitute a new major facility subject to preconstruction review requirements pursuant to Rule 62-212.400(2)(d)3., FAC, and Rule 2.401, JEPB.

This facility produces roasted coffee with batch and continuous roasters. The facility consists essentially of material handling, cleaning, roasting, cooling, grinding, and packaging operations.

The facility is a major source of air pollution because the potential emissions of regulated air pollutants are greater than 100 tons per year pursuant to Chapter 62-210, FAC, and JEPB Rule 2.301.

Subsection B. Summary of Emission Unit (EU) ID Nos. and Brief Descriptions

EU No.	EU Description	Control Device
553	Roasted Whole Bean Handling	(2) MAC Model 72 FRT 52 Baghouses and (1) DFF Sprout-Matador Type 21/2400S Baghouse
554	Green Bean Storage	(2) DFF Sprout-Matador Type 21/2400S Baghouses

Subsection C. Relevant documents

Title V Air Operation Permit Revision issued March 22, 2005
Air construction permit application received February 10, 2006

Section II. Facility Wide Conditions

Subsection A. General Conditions

1. The terms, conditions, requirements, limitations, and restrictions set forth herein are "Permit Conditions" and are binding and enforceable pursuant to Sections 403.141, 403.727, or 403.859 through 403.861, Florida Statutes. The permittee is placed on notice that the Department will review this permit periodically and may initiate enforcement action for any violation of these conditions.

2. This permit is valid only for the specific process and operations applied for and indicated in the approved drawings or exhibits. Any unauthorized deviation from the approved drawings, exhibits, specifications, or conditions of this permit may constitute grounds for revocation and enforcement action by the Department.

3. As provided in subsections 403.087(6) and 403.722(5), Florida Statutes, the issuance of this permit does not convey any vested rights or any exclusive privileges. Neither does it authorize any injury to public or private

property or any invasion of personal rights, nor any infringement of federal, state, or local laws or regulations. This permit is not a waiver of or approval of any other department permit that may be required for other aspects of the total project which are not addressed in this permit.

4. This permit conveys no title to land or water, does not constitute State recognition or acknowledgement of title, and does not constitute authority for the use of submerged lands unless herein provided and the necessary title or leasehold interests have been obtained from the State. Only the Trustees of the Internal Improvement Trust Fund may express State opinion as to title.

5. This permit does not relieve the permittee from liability for harm or injury to human health or welfare, animal, or plant life, or property caused by the construction or operation of this permitted source, or from penalties therefore, nor does it allow the permittee to cause pollution in contravention of Florida Statutes and Department rules, unless specifically authorized by an order from the Department.

6. The permittee shall properly operate and maintain the facility and systems of treatment and control (and related appurtenances) that are installed and used by the permittee to achieve compliance with the conditions of this permit, as required by Department rules. This provision includes the operation of backup or auxiliary facilities or similar systems when necessary to achieve compliance with the conditions of the permit and when required by Department rules.

7. The permittee, by accepting this permit, specifically agrees to allow authorized Department personnel, upon presentation of credentials or other documents as may be required by law and at reasonable times, access to the premises where the permitted activity is located or conducted to:
    a. Have access to and copy any records that must be kept under conditions of the permit;
    b. Inspect the facility, equipment, practices, or operations regulated or required under this permit; and
    c. Sample or monitor any substances or parameters at any location reasonably necessary to assure compliance with this permit or Department rules.

    Reasonable time may depend on the nature of the concern being investigated.

8. If, for any reason, the permittee does not comply with or will be unable to comply with any condition or limitation specified in this permit, the permittee shall immediately provide the Department with the following information:
    a. A description of and cause of noncompliance; and
    b. The period of noncompliance, including dates and times; or, if not corrected, the anticipated time the noncompliance is expected to continue, and steps being taken to reduce, eliminate, and prevent recurrence of the noncompliance. The permittee shall be responsible for any and all damages which may result and may be subject to enforcement action by the Department for penalties or revocation of this permit.

9. In accepting this permit, the permittee understands and agrees that all records, notes, monitoring data and other information relating to the construction or operation of this permitted source which are submitted to the Department may be used by the Department as evidence in any enforcement case involving the permitted source arising under the Florida Statutes or Department rules, except where such use is prescribed by Sections 403.111 and 403.73, Florida Statutes. Such evidence shall only be used to the extent it is consistent with the Florida Rules of Civil Procedure and appropriate evidentiary rules.

10. The permittee agrees to comply with changes in Department rules and Florida Statutes after a reasonable time for compliance; provided, however, the permittee does not waive any other rights granted by Florida Statutes or Department rules.

11. This permit is transferable only upon Department approval in accordance with Rules 62-4.120 and 62-730.300, FAC, as applicable. The permittee shall be liable for any noncompliance of the permitted activity until the transfer is approved by the Department.

12. This permit or a copy thereof shall be kept at the work site of the permitted activity.

13. This permit also constitutes:
    ( ) Determination of Best Available Control Technology (BACT)
    ( ) Determination of Prevention of Significant Deterioration (PSD)
    ( ) Certification of Compliance with State Water Quality Standards (Section 401, PL 92-500)
    ( ) Compliance with New Source Performance Standards

14. The permittee shall comply with the following:
    a. Upon request, the permittee shall furnish all records and plans required under Department rules. During enforcement actions, the retention period for all records will be extended automatically unless otherwise stipulated by the Department.
    b. The permittee shall hold at the facility or other location designated by this permit records of all monitoring information (including all calibration and maintenance records and all original strip chart recordings for continuous monitoring instrumentation) required by this permit, copies of all reports required by this permit, and records of all data used to complete the application for this permit. These materials shall be retained at least three years from the date of the sample, measurement, report, or application unless otherwise specified by Department rule.
    c. Records of monitoring information shall include:
        1. The date, exact place, and time of sampling or measurements;
        2. The person responsible for performing the sampling or measurements;
        3. The date(s) analyses were performed;
        4. The person responsible for performing the analyses;
        5. The analytical techniques or methods used;
        6. The results of such analyses.

15. When requested by the Department, the permittee shall within a reasonable time furnish any information required by law which is needed to determine compliance with the permit. If the permittee becomes aware that relevant facts were not submitted or were incorrect in the permit application or in any report to the Department, such facts or information shall be corrected promptly.
    [Rule 62-4.160, FAC, and Rule 2.1301, Jacksonville Environmental Protection Board (JEPB)]

Subsection B. Specific Conditions

1. Permittee shall notify the Department fifteen (15) days prior to EU testing.
   [Rule 62-297.310(7)(a)(9), FAC, and Rule 2.1101, JEPB]

2. Copies of the test report(s) shall be submitted to the Department within forty-five (45) days of completion of testing.
   [Rule 62-297.310(8)(b), FAC, and Rule 2.1101, JEPB]

3. Testing of emissions shall be conducted with the EU operating at permitted capacity. Permitted capacity is defined as 90-100 percent of the maximum operating rate allowed by the permit. If it is impracticable to test at permitted capacity, then EU may be tested at less than capacity; in this case subsequent EU operation is limited to 110 percent of the test load until a new test is conducted. Once the EU is so limited, then operation at higher capacities is allowed for no more than 15 consecutive days for the purposes of additional compliance testing to regain the permitted capacity in the permit.
   [Rule 62-297.310(2), FAC, and Rule 2.1101, JEPB]

4. Any revision(s) to a permit (and application) shall be submitted to and approved by the Department prior to implementing.
   [Rule 62-4.080(2), FAC, and Rule 2.1301, JEPB]

5. Control equipment shall be provided with a method of access that is safe and readily accessible.
   [Rule 62-297.310(6), FAC, and Rule 2.1101, JEPB]

6. Stack sampling facilities shall comply with the requirements of Rule 62-297.310(6), FAC, and Rule 2.1101, JEPB.

7. Permittee shall submit an annual operation report to the Department for this (these) emission unit(s) on the form(s) supplied for each calendar year on or before March 1.
   [Rule 62-210.370(3), FAC, and Rule 2.301, JEPB]

8. The construction/modification shall reasonably conform to the plans and schedule submitted in the application. If the permittee is unable to complete construction on schedule, the Department must be notified in writing sixty (60) days prior to the expiration of the construction permit. A new schedule and request for an extension of the construction permit must be submitted.
   [Rule 62-4.080(2), FAC, and Rule 2.1301, JEPB]

9. To obtain a permit to operate, the permittee must demonstrate compliance with the conditions of the construction permit and submit a complete application for a Title V Air Operating Permit with compliance records and test results, to the Department, at least one hundred eighty (180) days prior to the expiration date of the construction permit but no later than 180 days after completion of construction, whichever occurs first. The permittee may continue to operate in compliance with all terms of the construction permit until its expiration date. Operation beyond the construction permit expiration date requires a valid operating permit to operate.
   [Rule 62-210.300(2), FAC, Rule 62-213.420(1)(a)2., FAC, Rule 2.301, JEPB, and Rule 2.501, JEPB]

10. The permittee shall submit all compliance related notifications and reports required of this permit to:

Environmental Resource Management Department
Environmental Quality Division
117 West Duval Street, Suite 225
Jacksonville, FL 32202
Telephone: (904) 630-4900
Fax: (904) 630-3638

Section III. Emission Units and Conditions

Emissions Unit No. 553 – Roasted Whole Bean Handling

Emissions Unit Description - Whole roasted beans are processed from the Probat Roasters through a bean separator, bean cooler and a bag loading operations.

Control Device - (2) MAC Model 72 FRT 52 Baghouses and (1) DFF Sprout-Matador Type 21/2400S Baghouse

Essential Potential to Emit (PTE) Parameters

1. The maximum process rate shall not exceed 20,000 pounds per hour of green coffee beans.
   [Rule 62-210.200(211), FAC, and Rule 2.301, JEPB]

2. The nominal volumetric flow rate for each emissions point is as follows:

	Control Device	Cubic feet per minute
Bean separator	MAC Model 72 FRT 52	1,950
Bean cooler	DFF Type 21/2400S	2,400
Bag loading	MAC Model 72 FRT 52	1,950

   [Rule 62-210.200(211), FAC, 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(211), FAC, and Rule 2.301, JEPB]

Emission Limitations and Standards

4. Particulate matter (PM) emissions from the bean separator shall not exceed 0.016 grain per dry standard cubic foot, 0.27 pound per hour, and 1.17 tons per year.
   [Applicant's Request, Rule 62-296.711(2), FAC, and Rule 2.1001, JEPB]

5. PM emissions from the bean cooler shall not exceed 0.017 grain per dry standard cubic foot, 0.35 pound per hour, and 1.53 tons per year.
   [Applicant's Request, Rule 62-296.711(2), FAC, and Rule 2.1001, JEPB]

6. PM emissions from the bag loading operation shall not exceed 0.016 grain per dry standard cubic foot, 0.27 pound per hour, and 1.17 tons per year.
   [Applicant's Request, Rule 62-296.711(2), FAC, and Rule 2.1001, JEPB]

7. Visible emissions (VE) from each emissions point shall not exceed 5 percent opacity.
   [Rule 62-296.711(2), FAC, and Rule 2.1001, JEPB]

Test Methods and Procedures

8. 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), FAC, and Rule 2.1101, JEPB]

9. 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., FAC, and Rule 2.1101, JEPB]

Emissions Unit No. 554 – Green Bean Storage

Emissions Unit Description - Green coffee beans are transferred from storage bins to two green bean cleaners prior to being airveyed to storage bunkers.

Control Device - (2) DFF Sprout-Matador Type 21/2400S Baghouses

Essential Potential to Emit (PTE) Parameters

1. The maximum process rate shall not exceed 50,000 pounds per hour of green coffee beans.
   [Rule 62-210.200(211), FAC, and Rule 2.301, JEPB]

2. The nominal volumetric flow rate for each emissions point is 2,400 cubic feet per minute.
   [Rule 62-210.200(211), FAC, 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(211), FAC, and Rule 2.301, JEPB]

Emission Limitations and Standards

4. PM emissions (each emissions point) shall not exceed 0.017 grain per dry standard cubic foot, 0.35 pound per hour, and 1.53 tons per year.
   [Applicant's Request, Rule 62-296.711(2), FAC, and Rule 2.1001, JEPB]

5. VE (each emissions point) shall not exceed 5 percent opacity.
   [Rule 62-296.711(2), FAC, and Rule 2.1001, 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), FAC, and Rule 2.1101, 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., FAC, and Rule 2.1101, JEPB]

FILING AND ACKNOWLEDGMENT

FILED, on this date, pursuant to S.120.52(7), Florida Statutes, with the designated Department Clerk, receipt of which is hereby acknowledged.

_____ _____
Clerk Date