Florida Department of Environmental Protection

Northeast District
8800 Baymeadows Way West, Suite 100
Jacksonville, Florida 32256

Rick Scott
Governor

Carlos Lopez-Cantera
Lt. Governor

Jonathan P. Steverson
Secretary

PERMITTEE

Kraft Heinz Foods Company
735 E. Bay Street
Jacksonville, Florida 32202

Authorized Representative:
Bethany Mielke, Factory Manager

Air Permit No. 0310004-029-AC
Permit Expires: July 26, 2017
Minor Air Construction Permit

Kraft Heinz Foods Company
Three new Batch Roasters

PROJECT

This is the final air construction permit, which authorizes the installation of three additional Neotec batch roasters with a catalytic afterburner for each roaster, (3) Green Bean Batch Receivers, (3) Batch Cooling Cars, Batch Cold Chaff Receiver, (8) Roasted Whole Bean Storage Bins, and a mechanical Batch Destoner System for additional coffee roasting capacity. The proposed work will be conducted at the existing Kraft Heinz Foods Company, which is a Roasted Coffee facility categorized under Standard Industrial Classification No. 2095. The existing facility is located in Duval County at 735 E. Bay Street, in Jacksonville, Florida. The UTM coordinates are Zone 17, 437.5 km East and 3354.7 km North; Latitude: 30° 19' 27" North and Longitude: 81° 38' 53" West.

This final permit is organized into the following sections: Section 1 (General Information); Section 2 (Administrative Requirements); Section 3 (Emissions Unit Specific Conditions); and 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.

STATEMENT OF BASIS

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.
Permitting Program Administrator

FILING AND ACKNOWLEDGEMENT & CERTIFICATE OF SERVICE

Filed on this date pursuant to § 120.52, Florida Statutes, with the designated Department Clerk, receipt of which is hereby acknowledged. The undersigned hereby certifies that this Construction permit, Technical Evaluation, Combined Appendices, and all copies were sent before the close of business on July 26, 2016 to the listed persons.

Bethany Mielke, Factory Manager, Kraft Heinz Foods Company, (Bethany.Mielke@kraftheinzcompany.com)
George Whitmer, Whitmer Environmental Services, Inc., (george@whitmerenv.com)
Stephen Alexander, PE Consultant, Whitmer Environmental Services, Inc., (STEVEAIR57@yahoo.com)
Rick Brimo, Environmental Manager, Kraft Heinz Foods Company, (RBrimo@kraft.com)

Leslie Maybin — July 26, 2016
Clerk — Date

FACILITY DESCRIPTION

The existing facility consists of the following emissions units.

Emissions Unit – 501	GFM Boiler
Emissions Unit – 503	Thermalo Roasters
Emissions Unit – 504	Probat Roasters
Emissions Unit – 506	Batch Roasters
Emissions Unit – 509	Hot Chaff System
Emissions Unit – 510	(22) Bunkers
Emissions Unit – 511	GFM Bunkers
Emissions Unit – 512	Thermalo Green Bean Conveying System
Emissions Unit – 513	Thermalo Cooling Cars
Emissions Unit – 516	Probat Green Bean Feed System
Emissions Unit – 517	Probat Destoner Cooling Cars
Emissions Unit – 518	Probat Cold Chaff System
Emissions Unit – 519	Probat Scales
Emissions Unit – 524	Batch Green Bean Storage Silos
Emissions Unit – 525	Batch Roasters Green Bean Feed System
Emissions Unit – 526	Batch Cooling Cars
Emissions Unit – 527	Batch Destoners
Emissions Unit – 528	BAR Systems Nos. 1, 2 & 3
Emissions Unit – 529	Whole Roasted Bean Storage
Emissions Unit – 530	Gevalia and SIG-VAC Packaging Machines
Emissions Unit – 532	GFIC Sugar Unloading
Emissions Unit – 533	GFIC Minors Dump Station Receiving
Emissions Unit – 534	GFIC Majors Dump Station Receiving
Emissions Unit – 535	GFIC Finished Mix
Emissions Unit – 536	GFM Surge Bins
Emissions Unit – 537	GFM Bean Separator
Emissions Unit – 538	GFM Process
Emissions Unit – 539	Green Coffee Silos
Emissions Unit – 540	Green Coffee Silo Airveying
Emissions Unit – 550	GFM Drying Zone 1
Emissions Unit – 551	GFM Drying Zone 2
Emissions Unit – 552	GFM Drying Zone 3
Emissions Unit – 555	Fire Pump Diesel Engine
Emissions Unit – 556	BARs 1 and 2 Mixers
Emissions Unit – 557	Gevalia Green Bean Storage Tanks
Emissions Unit – 558	Process Dust Baghouse
Emissions Unit – 559	Tassimo Green Bean Storage Tanks
Emissions Unit – 560	Gevalia/Tassimo Destoners
Emissions Unit – 561	Hammer Mills
Emissions Unit – 562	(3) Decaff Bins each controlled with a Bin Vent Filter
Emissions Unit – 563	Green Silo Decaff #5 controlled with Dust Collector
Emissions Unit – 564	Green Silo Caff #4 controlled with Dust Collector
Emissions Unit – 565	(2) Probat Premium Destoners controlled with a Baghouse

PROPOSED PROJECT

Air construction, which authorizes the installation of three additional Neotec batch roasters which burn Natural Gas, with a catalytic afterburner for each roaster, (3) Green Bean Batch Receivers, (3) Batch Cooling Cars, Batch Cold Chaff Receiver, (8) Roasted Whole Bean Storage Bins, and a mechanical Batch Destoner System for additional coffee roasting capacity.

The existing facility green bean receiving and delivery system will supply the green coffee beans to two Neotec RFB-250 batch coffee roasters and one Neotec RFB-350xl batch coffee roaster with the capacity to roast 8,000 pounds of green coffee beans per hour and 10,000 pounds of green coffee beans respectively. Each batch roaster will have an independent green bean receiver batch cyclone that meters into dedicated green bean storage bins for each roaster.

Upon exiting the roasters, the roasted whole beans will be destoned and then chainveyed into eight new roasted whole bean storage bins. The particulates accumulated from the mechanical destoning process will be collected into a new baghouse. Each new roasted whole bean bin will have a mini-filter cartridge to purge the sealed internal air along with a canopy covering the bins. Air will not be escaping from these bins back into the atmosphere. The roasted whole beans will be discharged into the existing (EU528) BAR (blend after roast) systems and onto final packaging as determined by the production need.

This project will add the following emissions units.

Facility ID No. 0310004

ID No.	Emission Unit Description
566	(2) Batch Coffee Roasters 500 and 600 with the capacity to roast 8,000 pounds of green coffee beans per hour, and (1) Batch Coffee Roaster 700 with the capacity to roast 10,000 pounds of green coffee beans.
567	(3) Green Bean Batch Receivers 500, 600 and 700 (each with a cyclone that meters into dedicated green bean storage bins).
568	(3) Batch Cooling Cars 500, 600 (Two identical units) and Batch Cooling Car 700.
569	Batch Cold Chaff Receiver.
570	Batch Destoner System B3 with baghouse.

FACILITY REGULATORY CLASSIFICATION

- The facility **is not** a major source of hazardous air pollutants (HAP).
- The facility **does not** operate 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 62-213, F.A.C.
- The facility **is not** a major stationary source in accordance with Rule 62-212.400(PSD), F.A.C.

SECTION 2. ADMINISTRATIVE REQUIREMENTS

1. Permitting Authority: The permitting authority for this project is the Northeast District Office of the Department of Environmental Protection (Department). The Northeast District Office mailing address is 8800 Baymeadows Way W, Suite 100, Jacksonville, Florida 32256.

2. Compliance Authority: All documents related to compliance activities such as reports, tests, and notifications shall be submitted to the Northeast District Office, Compliance Assurance at: 8800 Baymeadows Way W, Suite 100, Jacksonville, Florida 32256.

3. Appendices: The following Appendices are attached as a part of this permit: Appendix A (Citation Formats and Glossary of Common Terms); Appendix B (General Conditions); Appendix C (Common Conditions); Appendix D (Common Testing Requirements) and Appendix D (Local Rules).

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. Construction and Expiration: The expiration date shown on the first page of this permit provides time to complete the physical construction activities authorized by this permit, complete any necessary compliance testing, and obtain an operation permit. Notwithstanding this expiration date, all specific emissions limitations and operating requirements established by this permit shall remain in effect until the facility or emissions unit is permanently shut down. For good cause, the permittee may request that a permit be extended. Pursuant to Rule 62-4.080(3), F.A.C., such a request shall be submitted to the Permitting Authority in writing before the permit expires. [Rules 62-4.070(3) & (4), 62-4.080 & 62-210.300(1), F.A.C.]

8. Source Obligation:

a. Authorization to construct shall expire if construction is not commenced within 18 months after receipt of the permit, if construction is discontinued for a period of 18 months or more, or if construction is not completed within a reasonable time. This provision does not apply to the time period between construction of the approved phases of a phased construction project except that each phase must commence construction within 18 months of the commencement date established by the Department in the permit.

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 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.

c. 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.]

9. Application for Title V Permit: This permit authorizes construction of the permitted emissions units 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 and Chapter 62-213, F.A.C.]

OO. Emissions Unit No. 566 Batch Coffee Roasters

This section of the permit addresses the following emissions units.

EU No.	Emission Unit Description
566	(2) Identical Batch Coffee Roasters 500 and 600, and (1) Batch Coffee Roaster (burns Natural Gas): EP01 Batch Coffee Roaster 500 with the capacity to roast 8,000 pounds of green coffee beans per hour. EP02 Batch Coffee Roaster 600 with the capacity to roast 8,000 pounds of green coffee beans per hour. EP03 Batch Coffee Roaster 700 with the capacity to roast 10,000 pounds of green coffee beans. Control Device: (3) Catalytic Afterburners.

{Brief descriptions of emissions units: (2) Neotec RFB-250 Batch Coffee Roasters with the capacity to roast 8,000 pounds of green coffee beans per hour. Stack height: 167 feet; (1) Neotec RFB-350xl Batch Coffee Roaster with the capacity to roast 10,000 pounds of green coffee beans per hour. Stack height: 167 feet; EU567 Stack height: 33 feet.}

{These emissions units are regulated under Reasonably Available Control Technology (RACT) Particulate Matter Rule 62-296.700(4)(a)6., F.A.C.; Reasonably Available Control Technology (RACT) Miscellaneous Manufacturing Process Operations, Rule 62-296.712(2), F.A.C.; Rule 2.301, JEPB; Rule 2.1101, JEPB; Rule 2.1201, JEPB; and Rule 2.1401, JEPB}

EQUIPMENT

OO.1. **Equipment Name**: The permittee is authorized to install **EU566** (2) Neotec RFB-250 Batch Coffee Roasters and (1) Neotec RFB-350xl Batch Coffee Roaster (or equivalent) which burn Natural Gas, with a Catalytic Afterburner for each roaster.

The construction shall be in accordance with the application and associated documents provided to the Permitting Authority for the issuance of this permit. Any changes to the project that are contrary to these documents and permit shall be reported in writing to the Permitting Authority by the P.E. of Record.

[Application No. 0310004-029-AC]

PERFORMANCE RESTRICTIONS

OO.2. **a. Permitted Capacity (EP01 and EP02)**: The maximum process rate for each roaster shall not exceed 8,000 pounds (4 TPH) and 10,000 (5 TPH) respectively of green coffee beans per hour.

b. Permitted Capacity (EP03): The maximum process rate for this roaster shall not exceed 10,000 pounds (5 TPH) of green coffee beans per hour.

[Application No. 0310004-029-AC, Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

OO.3. **Maximum Heat Input:** The combined maximum heat input rate for all (3) afterburners shall not exceed 6 MMBtu per hour of natural gas.

[Application No. 0310004-029-AC, Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

OO. Emissions Unit No. 566 Batch Coffee Roasters

OO.4. Volumetric Flow Rate:

a. EP01 and EP02: The nominal volumetric flow rate for these two roaster is 2,460 actual cubic feet per minute each.

b. EP03: The nominal volumetric flow rate for this roaster is 3,100 actual cubic feet per minute.

[Application No. 0310004-029-AC, Rule 62-210.200(PTE), F.A.C., Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

OO.5. Hours Operation: The hours of operation are limited to 24 hours/day, 7 days per week, 50 weeks per year (8400 hours per year) for each roaster.

[Application No. 0310004-029-AC Rules 62-4.070(3) and 62-210.200(PTE), F.A.C.]

EMISSIONS STANDARDS

OO.6. a). Particulate Matter Emissions ((EP01 and EP02): PM emissions for EP01 and EP02 shall not exceed 0.03 grain per dry standard cubic foot. Potential to emit 0.63 pound per hour, and 2.657 tons per year of PM.

b). Particulate Matter Emissions (EP03): PM emissions for EP03 shall not exceed 0.03 grain per dry standard cubic foot. Potential to emit 0.797 pound per hour, and 3.348 tons per year of PM.

[Applicant's Request, Rule 62-296.712(2), F.A.C., and Rule 2.1101, JEPB]

OO.7. Visible Emissions: Visible Emissions for each Batch Roaster shall not exceed 5 percent opacity.

[Rule 62-296.712(2), F.A.C. and Rule 2.1101, JEPB]

TESTING REQUIREMENTS

OO.8. Particulate Matter Emissions- Test Method: 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(5)(a), F.A.C., and Rule 2.1201, JEPB]

OO.9. Visible Emissions - Test Method: 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. The required minimum period of observation for a visible emissions test shall be 30 minutes for emissions units, except that for batch, cyclical processes, or other operations that are typically completed within less than the minimum observation period, the period of observation shall include each occurrence of the operation during the minimum observation period. The opacity test observation period shall include the period during which the highest opacity emissions can reasonably be expected to occur.

[Rule 62-297.310(5)(b), F.A.C., and Rule 2.1201, JEPB]

OO.10. Initial Compliance Tests: Particulate Matter and Visible Emissions shall be tested to demonstrate initial compliance with the emissions standards. The initial tests shall be conducted within 60 days after achieving permitted capacity, but not later than 180 days after initial operation of the unit.

[Rules 62-4.070(3) and 62-297.310(8)(b)1, F.A.C.]

OO.11. **Annual Compliance Tests**: During each calendar year (January 1st to December 31st), Particulate Matter and Visible Emissions shall be tested to demonstrate compliance with the emissions standards on one Roaster (alternating Roaster units each year).

[Rule 62-297.310(8)(a)1, F.A.C., Rule 2.1401, JEPB; Application No. 0310004-029-AC]

OO.12. **Test Requirements**: The permittee shall notify the Compliance Authority in writing at least 15 days prior to any required tests. Tests shall be conducted in accordance with the applicable requirements specified in Appendix D (Common Testing Requirements) of this permit.

[Rule 62-297.310(9), F.A.C.]

MONITORING REQUIREMENTS

OO.13. **Afterburner Operating Temperature:** Each afterburner shall maintain a minimum operating temperature of 770° F

[Rule 62-296.700(4)(a)6., F.A.C., and Rule 2.1101, JEPB]

OO.14. **Afterburner – Temperature Measurement:** The owner or operator shall install, calibrate, maintain, and operate a temperature measurement device for each afterburner.

[Rule 62-296.700(4)(a)6., F.A.C., and Rule 2.1101, JEPB]

RECORDS AND REPORTS

OO.15. **Test Reports**: The permittee shall prepare and submit reports for all required tests in accordance with the requirements specified in Appendix D (Common Testing Requirements) of this permit. For each test run, the report shall also indicate the maximum process rate and nominal volumetric flow rate for each EU.

[Rule 62-297.310(10), F.A.C.]

OO.16. **Operation and Maintenance Plan:** This EU is subject to the Operation and Maintenance Plan in the attached Combined Appendices.

[Rule 62-296.700(6), FAC, Rule 2.1101, JEPB]

OO.17. **Commencement of Construction and Operation.** After the construction of each Batch Coffee Roasters 500, 600 and 700 (**EU566)** is installed, the permittee shall submit to the Air Compliance Authority of this Office written notifications of the date of commencement of construction and operation of (**EU566)**. These notifications shall be submitted or postmarked to Christopher.Kirts@dep.state.fl.us within as many days prior to the date of construction and operation commencement as practical, but no later than thirty (30) business day following commencement of construction and operation.

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

OO.18. This Facility is subject to SECTION 2. Administrative Requirements of this permit and also, the attached Combined Appendices.

PP. EU567 (3) Green Bean Batch 500, 600 and 700 Receivers

This section of the permit addresses the following emissions unit.

EU No.	Emission Unit Description
567	(3) Green Bean Batch Receivers 500, 600 and 700 (each with a cyclone that meters into dedicated green bean storage bins)**.** **EP01** Green Bean Batch Receiver 500. Control Device – Green Bean Batch Receiver 500: Kice VR Venturi Jet Filter, VR16-8 (or equivalent). **EP02** Green Bean Batch Receiver 600. Control Device – Mac Pulse Jet Filter, 72AVR21 style III filter (or equivalent). **EP03** Green Bean Batch Receiver 700. Control Device –Kice Venturi Jet Filters, Model VR21-10H (or equivalent).

{Brief descriptions of emissions units: Green Bean Batch Receiver 500. Stack height: 160 feet. Green Bean Batch Receiver 600. Stack height: 165 feet. Green Bean Batch Receiver 700. Stack height: 173 feet.}

{These emissions units are regulated under Reasonably Available Control Technology (RACT) Particulate Matter Rule 62-296.700(6), F.A.C.; Reasonably Available Control Technology (RACT) Miscellaneous Manufacturing Process Operations, Rule 62-296.712(2), F.A.C.; Rule 2.301, JEPB; Rule 2.1201, JEPB}

EQUIPMENT

PP.1. **Equipment Name**: The permittee is authorized to install EU567 (3) Green Bean Batch Receivers 500, 600 and 700 with bag filters for each emissions point.

The construction shall be in accordance with the application and associated documents provided to the Permitting Authority for the issuance of this permit. Any changes to the project that are contrary to these documents and permit shall be reported in writing to the Permitting Authority by the P.E. of Record.

[Application No. 0310004-029-AC]

PERFORMANCE RESTRICTIONS

PP.2. **Permitted Capacity**: The maximum process rate for each EP shall not exceed 21 tons per hour of green coffee beans.

[Rule 62-210.200, FAC, and Rule 2.301, JEPB]

PP.3. **Volumetric Flow Rate**: The nominal volumetric flow rate for each EP is 1,590 actual cubic feet per minute.

[Application No. 0310004-029-AC, Rule 62-210.200(PTE), F.A.C., Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

PP.4. **Hours Operation**: The hours of operation are limited to 24 hours/day, 7 days per week, 50 weeks per year (8400 hours per year) for each EP.

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

PP. EU567 (3) Green Bean Batch 500, 600 and 700 Receivers

EMISSIONS STANDARDS

PP.5. **Particulate Matter Emissions:** PM emissions for each EP shall not exceed 0.03 grain per dry standard cubic foot. Potential to emit 0.409 pound per hour, and 1.72 tons per year of PM for each EP.

[Applicant's Request, Rule 62-296.712(2), F.A.C., and Rule 2.1101, JEPB]

PP.6. **Visible Emissions:** Visible Emissions for each EP shall not exceed 5 percent opacity.

[Rule 62-296.712(2), F.A.C. and Rule 2.1101, JEPB]

TESTING REQUIREMENTS

PP.7. **Particulate Matter Emissions- Test Method:** 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(5)(a), F.A.C., and Rule 2.1201, JEPB]

PP.8. **Visible Emissions- Test Method:** 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. The required minimum period of observation for a visible emissions test shall be 30 minutes for emissions units, except that for batch, cyclical processes, or other operations that are typically completed within less than the minimum observation period, the period of observation shall include each occurrence of the operation during the minimum observation period. The opacity test observation period shall include the period during which the highest opacity emissions can reasonably be expected to occur.

[Rule 62-297.310(5)(b), F.A.C., and Rule 2.1201, JEPB]

PP.9. **Initial Compliance Tests**: Each EP shall be tested to demonstrate initial compliance with the emissions standards for PM and VE. The initial tests shall be conducted within 60 days after achieving permitted capacity, but not later than 180 days after initial operation of the unit.

[Rules 62-4.070(3) and 62-297.310(8)(b)1, F.A.C.]

PP.10. **Annual Compliance Tests**: During each calendar year (January 1st to December 31st), each EP shall be tested to demonstrate compliance with the emissions standards for PM and VE.

[Rule 62-297.310(8)(a)1, F.A.C.]

PP.11. **Test Requirements**: The permittee shall notify the Compliance Authority in writing at least 15 days prior to any required tests. Tests shall be conducted in accordance with the applicable requirements specified in Appendix D (Common Testing Requirements) of this permit.

[Rule 62-297.310(9), F.A.C.]

RECORDS AND REPORTS

PP.12. **Test Reports**: The permittee shall prepare and submit reports for all required tests in accordance with the requirements specified in Appendix D (Common Testing Requirements) of this permit. For each test run, the report shall also indicate the maximum process rate and nominal volumetric flow rate.

[Rule 62-297.310(10), F.A.C.]

PP.13. **Operation and Maintenance Plan:** The facility is subject to the Operation and Maintenance Plan in the attached Combined Appendices.

[Rule 62-296.700(6), FAC, Rule 2.1101, JEPB and Application No. 0310004-029-AC]

PP.14. **Commencement of Construction and Operation.** After the construction of (3) Green Bean Batch Receivers 500, 600 and 700 (**EU567)** is installed, the permittee shall submit to the Air Compliance Authority of this Office written notifications of the date of commencement of construction and operation of **EU567**. These notifications shall be submitted or postmarked to Christopher.Kirts@dep.state.fl.us within as many days prior to the date of construction and operation commencement as practical, but no later than thirty (30) business day following commencement of construction and operation.

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

PP.15. This Facility is subject to SECTION 2. Administrative Requirements of this permit and also, the attached Combined Appendices.

QQ. EU568 (3) Batch Cooling Cars 500, 600 and 700

This section of the permit addresses the following emissions unit.

EU No.	Emission Unit Description
568	(3) Batch Cooling Cars: EP01 Cooling Car 500. EP02 Cooling Car 600. EP03 Cooling Car 700. Control Equipment: Each EP is controlled by a Centrifugal collector medium efficiency (80.0-94.9%)

{Brief descriptions of emissions units: (2) Identical Batch Cooling Cars 500, 600. Stack height: 167 feet; (1) Cooling Car 700. Stack height: 159 feet}

{This emissions unit is regulated under Reasonably Available Control Technology (RACT) Miscellaneous Manufacturing Process Operations, Rule 62-296.711(2), F.A.C.; Rule 2.301, JEPB; Rule 2.1101, JEPB; Rule 2.1201, JEPB; and Rule 2.1401, JEPB}

EQUIPMENT

QQ.1. **Equipment Name**: The permittee is authorized to install EU568 - Cooling Cars 500, 600 (Two identical units), and Cooling Car 700 each with a cyclone.

The construction shall be in accordance with the application and associated documents provided to the Permitting Authority for the issuance of this permit. Any changes to the project that are contrary to these documents and permit shall be reported in writing to the Permitting Authority by the P.E. of Record.

[Application No. 0310004-029-AC]

QQ.2. **a). Permitted Capacity:** The maximum process rate for each EP 01 and EP02 shall not exceed 4 tons per hour of beans fed to the roaster.

QQ.3. **b). Permitted Capacity:** The maximum process rate for EP03 shall not exceed 5 tons per hour of beans fed to the roaster.

[Application No. 0310004-029-AC, Rule 62-210.200, F.A.C, and Rule 2.301, JEPB]

QQ.4. **a). Volumetric Flow Rate (EP01 and EP02):** The nominal volumetric flow rate for each EP01 and EP02 is 5,151 actual cubic feet per minute.

b). Volumetric Flow Rate (EP03): The nominal volumetric flow rate this EP is 6,475 actual cubic feet per minute.

[Rule 62-210.200, FAC, and Rule 2.301, JEPB]

QQ.5. **Hours of Operation:** The hours of operation are limited to 24 hours/day, 7 days per week, 50 weeks per year (8400 hours per year) for each EP.

[Application No. 0310004-029-AC, Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

QQ. EU568 (3) Batch Cooling Cars 500, 600 and 700

EMISSIONS STANDARDS

QQ.6. **a). Particulate Matter Emissions (EP01 and EP02):** PM emissions for EP01 and EP02 shall not exceed 0.03 grain per dry standard cubic foot. Potential to emit 1.32 pound per hour, and 5.56 tons per year of PM for each EP.

b). Particulate Matter Emissions (EP03): PM emissions for EP03 shall not exceed 0.03 grain per dry standard cubic foot. Potential to emit 1.665 pound per hour, and 6.99 tons per year of PM.

[Applicant's Request, Rule 62-296.711(2), FAC, and Rule 2.1101, JEPB]

QQ.7. **Visible emissions:** Visible Emissions for each EP shall not exceed 5 percent opacity.

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

TESTING AND FREQUENCY REQUIREMENTS

QQ.8. **Particulate Matter Emissions- Test Method and Frequency**: 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. For each EP Particulate Matter Emissions shall be tested annually, each federal fiscal year (October 1 – September 30).

[Rules 62-4.070(3), F.A.C., 62-296.711(3)(b), F.A.C., 62-297.310(8)(a)1., F.A.C., Rule 2.1201, JEPB, Rule 2.1401, JEPB; and Application No. 0310004-029-AC]

QQ.9. **Visible Emissions- Test Method and Frequency:** 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. For each EP VE shall be tested annually, each federal fiscal year (October 1 – September 30).

[Rules 62-296.711(3)(a), F.A.C., 62-297.310(8)(a)1., F.A.C., Rule 2.1201, JEPB, Rule 2.1401, JEPB and Application No. 0310004-029-AC]

QQ.10. **Test Requirements**: The permittee shall notify the Compliance Authority in writing at least 15 days prior to any required tests. Tests shall be conducted in accordance with the applicable requirements specified in Appendix D (Common Testing Requirements) of this permit.

[Rule 62-297.310(9), F.A.C.]

RECORDS AND REPORTS

QQ.11. **Test Reports**: The permittee shall prepare and submit reports for all required tests in accordance with the requirements specified in Appendix D (Common Testing Requirements) of this permit. For each test run, the report shall also indicate the maximum process rate and nominal volumetric flow rate for each EU.

[Rule 62-297.310(10), F.A.C.]

QQ.12. **Commencement of Construction and Operation.** After the construction of (3) Batch Cooling Cars at **EU568** is installed, the permittee shall submit to the Air Compliance Authority of this Office written notifications of the date of commencement of construction and operation of **EU568**. These notifications shall be submitted or postmarked to Christopher.Kirts@dep.state.fl.us within as many days prior to the date of construction and operation commencement as practical, but no later than thirty (30) business day following commencement of construction and operation.
[Rule 62-4.070(3), F.A.C.]

QQ. EU568 (3) Batch Cooling Cars 500, 600 and 700

QQ.13. This Facility is subject to SECTION 2. Administrative Requirements of this permit and also, the attached Combined Appendices.

RR. EU569 Batch Cold Chaff Receiver

This section of the permit addresses the following emissions unit.

EU No.	Emission Unit Description
569	Batch Cold Chaff Receiver. Control Device: Baghouse

{Brief descriptions of emissions units: Batch Cold Chaff Receiver removes debris from destoner and cold side of roaster. Stack height: 46 feet.}

{This emissions unit is regulated under Reasonably Available Control Technology (RACT) Particulate Matter Rule 62-296.700(4)(a)6., F.A.C.; Reasonably Available Control Technology (RACT) Miscellaneous Manufacturing Process Operations, Rule 62-296.712(2), F.A.C.; Rule 2.301, JEPB; Rule 2.1101, JEPB; Rule 2.1201, JEPB; and Rule 2.1401, JEPB}

EQUIPMENT

RR.1. **Equipment Name**: The permittee is authorized to install EU569 Batch Cold Chaff Receiver with a baghouse.

The construction shall be in accordance with the application and associated documents provided to the Permitting Authority for the issuance of this permit. Any changes to the project that are contrary to these documents and permit shall be reported in writing to the Permitting Authority by the P.E. of Record.

[Application No. 0310004-029-AC]

PERFORMANCE RESTRICTIONS

RR.2. **Permitted Capacity:** The maximum process rate for the Batch Cold Chaff Receiver shall not exceed 2 tons per hour.

[Application No. 0310004-029-AC; Rule 62-210.200, F.A.C., and Rule 2.301, JEPB]

RR.3. **Volumetric Flow Rate**: The nominal volumetric flow rate is 1,200 actual cubic feet per minute.

[Rule 62-210.200, FAC, and Rule 2.301, JEPB]

RR.4. **Hours Operation**: The hours of operation are limited to 24 hours/day, 7 days per week, 50 weeks per year (8400 hours per year).

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

EMISSIONS STANDARDS

RR.5. **Particulate Matter Emissions:** PM emissions shall not exceed 0.03 grain per dry standard cubic foot. Potential to emit 0.308 pound per hour, and 1.3 tons per year.

[Applicant's Request, Rule 62-296.712(2), F.A.C., and Rule 2.1101, JEPB]

RR.6. **Visible emissions:** Visible Emissions shall not exceed 5 percent opacity.

[Rule 62-296.712(2), F.A.C., and Rule 2.1101, JEPB]

RR. EU569 Batch Cold Chaff Receiver

TESTING AND FREQUENCY REQUIREMENTS

RR.7. **Visible Emissions- Test Method and Frequency:** VE shall be tested annually, each federal fiscal year (October 1 – September 30). 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. Test procedures shall meet all applicable requirements of Chapter 62-297, F.A.C.

[Rules 62-4.070(3), F.A.C., 62-297.310(8)(a)1., F.AC., Rule 2.1401, JEPB; Rule 62-296.712(3)(a), and (d), F.A.C., and Application No. 0310004-029-AC]

RR.8. **Particulate Matter- Test Method and Frequency:** Particulate Matter Emissions shall be tested annually, each federal fiscal year (October 1 – September 30). 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. Test procedures shall meet all applicable requirements of Chapter 62-297, F.A.C.

[Rules 62-4.070(3), F.A.C., 62-297.310(8)(a)1., F.A.C., Rule 2.1401, JEPB; Rule 62-296.712(3)(b), and (d), F.A.C., Application No. 0310004-029-AC]

RR.9. **Test Requirements**: The permittee shall notify the Compliance Authority in writing at least 15 days prior to any required tests. Tests shall be conducted in accordance with the applicable requirements specified in Appendix D (Common Testing Requirements) of this permit.

[Rule 62-297.310(9), F.A.C.]

RECORDS AND REPORTS

RR.10. **Test Reports**: The permittee shall prepare and submit reports for all required tests in accordance with the requirements specified in Appendix D (Common Testing Requirements) of this permit. For each test run, the report shall also indicate the maximum process rate and nominal volumetric flow rate for each EU.

[Rule 62-297.310(10), F.A.C.]

RR.11. **Commencement of Construction and Operation:** After the construction of the Batch Cold Chaff Receiver **EU569** is installed, the permittee shall submit to the Air Compliance Authority of this Office written notifications of the date of commencement of construction and operation of **EU569**. These notifications shall be submitted or postmarked to Christopher.Kirts@dep.state.fl.us within as many days prior to the date of construction and operation commencement as practical, but no later than thirty (30) business day following commencement of construction and operation.

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

RR.12. This Facility is subject to SECTION 2. Administrative Requirements of this permit and also, the attached Combined Appendices.

SS. EU570 Batch Destoner System B3

This section of the permit addresses the following emissions unit.

EU No.	Emission Unit Description
570	Batch Destoner System B3. Control Equipment: Baghouse.

{Brief descriptions of emissions unit: Batch Destoner System B3 is used to remove stones and other waste from the roasted beans that were not removed in the initial cleaning process. Stack height: 79 feet.}

{These emissions units are regulated under Reasonably Available Control Technology (RACT) Miscellaneous Manufacturing Process Operations, Rule 62-296.712(2), F.A.C.; Rule 2.301, JEPB; Rule 2.1101, JEPB; and Rule 2.1201, JEPB}

EQUIPMENT

SS.1. **Equipment Name**: The permittee is authorized to install EU571 Batch Destoner System B3 with baghouse.

The construction shall be in accordance with the application and associated documents provided to the Permitting Authority for the issuance of this permit. Any changes to the project that are contrary to these documents and permit shall be reported in writing to the Permitting Authority by the P.E. of Record.

[Application No. 0310004-029-AC]

SS.2. **Permitted Capacity:** The maximum process rate shall be limited to 11 tons per hour of coffee beans.

[Application No. 0310004-029-AC, Rule 62-210.200, FAC, and Rule 2.301, JEPB]

SS.3. **Volumetric Flow Rate:** The nominal volumetric flow rate is 14, 650 actual cubic feet per minute.

[Application No. 0310004-029-AC, Rule 62-210.200(PTE), F.A.C., Rule 62-210.200, FAC, and Rule 2.301, JEPB]

SS.4. **Hours of Operation:** The hours of operation for this emissions unit shall not exceed 8400 hours per year.

[Application No. 0310004-029-AC, Rule 62-4.070(3), F.A.C., and Rule 2.1401, JEPB]

EMISSION LIMITATIONS AND STANDARDS

SS.5. **Particulate Matter Emissions:** PM emissions from the Batch Destoner System B shall not exceed 0.02 grain per dry standard cubic foot, potential to emit 2.511 lbs per hour, 10.548 ton per year.

[Applicant's Request, Application No. 0310004-029-AC, and Rule 2.1101, JEPB

SS.6. **Visible emissions:** Visible Emissions shall not exceed 5 percent opacity.

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

SS. EU570 Batch Destoner System B3

TESTING REQUIREMENTS AND FREQUENCY

SS.7. **Particulate Matter Emissions- Test Method:** 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 62-296.711(3)(b), F.A.C., and Rule 2.1201, JEPB]

SS.8. **Visible Emissions - Test Method:** 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. The required minimum period of observation for a visible emissions test shall be 30 minutes for emissions units, except that for batch, cyclical processes, or other operations that are typically completed within less than the minimum observation period, the period of observation shall include each occurrence of the operation during the minimum observation period. The opacity test observation period shall include the period during which the highest opacity emissions can reasonably be expected to occur.

[Rule 62-296.711(3)(a), F.A.C., and Rule 2.1201, JEPB]

SS.9. **Initial Compliance Tests**: This EU shall be tested to demonstrate initial compliance with the emissions standards for PM and VE. The initial tests shall be conducted within 60 days after achieving permitted capacity, but not later than 180 days after initial operation of the unit.

[Rules 62-4.070(3) and 62-297.310(8)(b)1, F.A.C.]

SS.10. **Annual Compliance Tests**: During each calendar year (January 1st to December 31st), this EU shall be tested to demonstrate compliance with the emissions standards for PM and VE.

[Rule 62-297.310(8)(a)1, F.A.C.]

SS.11. **Test Requirements**: The permittee shall notify the Compliance Authority in writing at least 15 days prior to any required tests. Tests shall be conducted in accordance with the applicable requirements specified in Appendix D (Common Testing Requirements) of this permit.

[Rule 62-297.310(9), F.A.C.]

RECORDS AND REPORTS

SS.12. **Test Reports**: The permittee shall prepare and submit reports for all required tests in accordance with the requirements specified in Appendix D (Common Testing Requirements) of this permit. For each test run, the report shall also indicate the maximum process rate and nominal volumetric flow rate for each EU.

[Rule 62-297.310(10), F.A.C.]

SS.13. **Commencement of Construction and Operation.** After the construction of the Batch Destoner System is installed, the permittee shall submit to the Air Compliance Authority of this Office written notifications of the date of commencement of construction and operation of (**EU570)**. These notifications shall be submitted or postmarked to Christopher.Kirts@dep.state.fl.us within as many days prior to the date of construction and operation commencement as practical, but no later than thirty (30) business day following commencement of construction and operation.

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

SS.14. This Facility is subject to SECTION 2. Administrative Requirements of this permit and also, the attached Combined Appendices.